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USPTO FORM 1001 (REV. 11-2000) 09/18/98 376 Not Yet Known	INTERNATIONAL APPLICATION NO. PCT/EP98/08509	ATTORNEY'S DOCKET NUMBER SMB-PT026 (PC 98 653 B US
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21 ☐ The following fees are submitted:

BASIC NATIONAL FEE (37 CFR 1.992 (a) (1) - (5)):
 Neither international preliminary examination fee (37 CFR 1.482)
 nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO
 and International Search Report not prepared by the EPO or JPO ☐ \$1000.00

International preliminary examination fee (37 CFR 1.482) not paid to
 USPTO but International Search Report prepared by the EPO or JPO ☐ \$860.00

International preliminary examination fee (37 CFR 1.482) not paid to USPTO
 but international search fee (37 CFR 1.445(a)(2)) paid to USPTO ☐ \$710.00

International preliminary examination fee (37 CFR 1.482) paid to USPTO
 but all claims did not satisfy provisions of PCT Article 33(1)-(4) ☐ \$690.00

International preliminary examination fee (37 CFR 1.482) paid to USPTO
 and all claims satisfied provisions of PCT Article 33(1)-(4) ☐ \$1000.00

ENTER APPROPRIATE BASIC FEE AMOUNT =

	\$	860
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Surcharge of \$130.00 for furnishing the oath or declaration later than ☐ 20 ☐ 30
 months from the earliest claimed priority date (37 CFR 1.992(f)) ☐

	\$	0
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CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE	\$
Total claims	42 - 20 =	22	x \$18.00	\$ 396
Independent claims	3 - 3 =	0	x \$80.00	\$ 0
MULTIPLE DEPENDENT CLAIM(S) (if applicable)				+ \$270.00
TOTAL OF ABOVE CALCULATIONS =				\$ 1256

☐ Applicant claims small entity status ☐ See 37 CFR 1.27 ☐ The fees indicated above
 are reduced by 1/2 ☐

SUBTOTAL =	\$	1256
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Processing fee of \$130.00 for furnishing the English translation later than ☐ 20 ☐ 30
 months from the earliest claimed priority date (37 CFR 1.992(f)) ☐

TOTAL NATIONAL FEE =	\$	1256
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Fee for recording the enclosed assignment (37 CFR 1.21(h)) ☐ The assignment must be
 accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) ☐ \$40.00 per property +

TOTAL FEES ENCLOSED =	\$	1296
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	Amount to be refunded:	\$
	charged:	\$

a ☒ A check in the amount of \$ 1296 to cover the above fees is enclosed ☐

b ☐ Please charge my Deposit Account No. 22-0493 in the amount of \$ _____ to cover the above fees ☐
 A duplicate copy of this sheet is enclosed ☐

c ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any
 overpayment to Deposit Account No. 22-0493 ☐ A duplicate copy of this sheet is enclosed ☐

d ☐ Fees are to be charged to a credit card ☐ **WARNING:** Information on this form may become public ☐ Credit card
 information should not be included on this form ☐ Provide credit card information and authorization on PTO-2038 ☐

NOTE: Where an appropriate time limit under 37 CFR 1.994 or 1.995 has not been met, a petition to revive (37 CFR
 1.937 (a) or (b)) must be filed and granted to restore the application to pending status ☐

SEND ALL CORRESPONDENCE TO
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 Suite 400, One Penn Center
 1617 John F. Kennedy Boulevard
 Philadelphia, PA 19103

SIGNATURE
 Randolph J. Huis, Esquire
 NAME
 34,626
 REGISTRATION NUMBER

FORM PTO-1100 (REV. 11-2000) page 2 of 2

Express Mail Label No. EL722983910US

**APPLICATION DATA SHEET
UNDER 37 CFR §1.76****(1) Inventor Information**

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(4) Application Information

Title Line One:: METHOD AND INJECTION MOLDING MACHINE
Title Line Two:: FOR PRODUCING INJECTION-MOLDED
Title Line Three:: ARTICLES, ESPECIALLY TOOTHBRUSH
Title Line Four:: BODIES OR TOOTHBRUSHES
Total Drawing Sheets: 8
Drawing Type:: Formal
Application Type:: Utility
Docket No.: SMB-PT026 (PC 98 653 B US)

(5) Representative Information

Representative Customer No.: 3624

(6) Domestic Priority Information

This application is a:: National Phase
>Application One:: PCT/EP98/08509
Filing Date:: 12/30/1998

Express Mail Label No. EL722983910US
PATENT

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In the **PATENT APPLICATION** of:

Zahoransky et al.

Our File: SMB-PT026
 (PC 98 653 B US)

PCT Appln. No.: PCT/EP98/08509

Application No.: Not Yet Known

Date: June 29, 2001

Filed: Not Yet Known

For: METHOD AND INJECTION MOLDING
 MACHINE FOR PRODUCING INJECTION-
 MOLDED ARTICLES, ESPECIALLY
 TOOTHBRUSH BODIES OR TOOTHBRUSHES

Group: Not Yet Known

Examiner: Not Yet Known

PRELIMINARY AMENDMENT

Box PCT
 Commissioner for Patents
 Washington, D.C. 20231

Sir:

Prior to examination, please amend the application as provided by the Translation of PCT/EP98/08509 and the Translation of Annexes to International Preliminary Examination Report for PCT/EP98/08509, as shown in detail below. A Substitute Specification incorporating the Annexes as well as these amendments to the application is attached.

IN THE SPECIFICATION

On page 3, before paragraph [0009], insert the following new paragraph:

--SUMMARY OF THE INVENTION--.

On page 5, before paragraph [0041], insert the following new paragraph:

--BRIEF DESCRIPTION OF THE DRAWINGS--.

On page 6, before paragraph [0052], insert the following new paragraph:
--DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS--.

IN THE CLAIMS

Please amend the claims, without prejudice, as follows:

3. (Amended) A process in accordance with Claim 1, characterized in that the additive material (8) is introduced in a plurality of locations of the distribution arrangement.
4. (Amended) A process in accordance with Claim 1, characterized in that the additive material (8) is metered to the injection material by dosages.
5. (Amended) A process in accordance with Claim 1, characterized in that the introduction of the additive (8) is blocked during a post-pressure phase of the injection molding process.
6. (Amended) A process in accordance with Claim 1, characterized in that the additive (8) is introduced to the injection material at approximately the same temperature as that of the injection material.
8. (Amended) An injection molding machine for the manufacture of injection molded articles, in particular of toothbrush bodies, with an injection molding die (1) and an injection unit (2) mold cavities (5), a distributor channel arrangement (4) with distributor or conveyance channels (150) that carry injection material between the injection unit (2) and individual mold cavities (5) and at least one mixing apparatus (450) for the injection material, and at least one connection for an additive line, wherein the mixing apparatus and the additive line are integrated into the distributor channel

arrangement (4, 4a, 100), and

that the mixing apparatus is part of the distributor or conveyance channels (150) of the distributor arrangement (4) and that the additive feed(s) for the additive (8) is (are) connected to the channel main distributor (6) or the channel subdistributor (14) connected to the injection unit (2) and/or in a nozzle connected to the mold cavity.

10. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the feed (10) for the additive material (8) can be closed.

11. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the shutoff valve (15) is designed as a dosage valve for the additive material (8).

12. (Amended) An injection molding machine in accordance with Claim 8, characterized in that in a case of a plurality of line connections for additives (8), at least one is connected directly to a mold cavity (5).

13. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the mixing apparatus includes at least one mixing chamber (17) formed by a cross-sectional change, preferably by a cross-sectional expansion.

14. (Amended) An injection molding machine in accordance with Claim 8, characterized in that a hot channel distributor (100) is provided for handling of melts (101), which, before injection into the mold cavities have been mixed with at least one additive material, and the hot channel distributor (100) includes a melt channel (150) arrangement, in which at least one feed line section (151) is provided for delivery of the additive material (102), an additive material line, with a terminating outlet into the feed

line section (151), at least one mixer (300) aligned in a direction of flow, and in that the mixer (300) is formed as a mixing section which includes at least two sections (301, 302), the axes of which are not aligned to coincide with one another.

17. (Amended) An injection molding machine in accordance with Claim 15, characterized in that by the use of a plurality of mixers (300) the length and the cross-section of the single mixing sections are made equal for the attainment of balanced flow ratios.

18. (Amended) An injection molding machine in accordance with Claim 14, characterized in that the exit opening (303) of the first section (301) is connected to the entry opening (304) of the second section (302) of the two sections (301, 302), by a flow direction reversal fitting (305) of the melt channel (150), wherein the direction of flow in the first section (301) is essentially opposite to the direction of flow in the second section (302).

22. An injection molding machine in accordance with Claim 18, characterized in that the first and the second sections (301, 302) are respectively provided as static mixers (450).

24. (Amended) An injection molding machine in accordance with Claim 22, characterized in that the two static mixers elements (450) comprise a plurality of screw shaped, twisting deflection plates (451, 452), which are arranged alternately right and left behind one another, wherein each deflection plate (451) possesses two edges (453) standing at right angles to the material flow direction, which are connected with the respective adjacent edge (454) of the neighboring deflection plate (452), and are turned through a specified angle in relation to said edge (454).

26. An injection molding machine in accordance with Claim 24, characterized in that the adjacent edges (453, 454) of neighboring deflection plates (451, 452) are connected together by spot welding.

34. (Amended) An injection molding machine in accordance with Claim 32, characterized in that the needle valve (203) travel is limited to 0.1 to 0.01 mm.

35. (Amended) An injection molding machine in accordance with Claim 8, characterized in that within the distribution channel, a separating distance to the entry point of an additive feed (10) from a mold cavity, is determined in consideration of a volume of the article to be produced by injection molding and by an anticipated volume of additive required for the article.

36. (Amended) An injection molding machine in accordance with Claim 8, characterized in that a temperature adjustment apparatus is provided for the additive 8, preferably by means of a heating installation placed at the additive material feed (10).

37. (Amended) An injection molding machine in accordance with Claim 8, characterized in that one or more distributor channel branches include one or more additive material feeds (10).

38. (Amended) An injection molding machine in accordance with Claim 8, characterized in that a plurality of additive feeds (10) are provided in a channel leading to the mold cavities (5) in the direction of flow, and in that the additive feeds (10) can be optionally closed.

39. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the entry of the additive feed (10) at the distributor channel is designed as an annular opening.

40. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the additive feed (10) includes a feed line (11), a material propelling means, which is preferably formed by a pump (12) as well as an additive storage container (13).

41. (Amended) An injection molding machine in accordance with Claim 8, characterized in that the additive includes at least one of the following: color (8), preferably in liquid form, granulates, powder, metal platelets, protective material, reinforcing material, mold release means, chemically active additives such as foam agents for cellular products, hardeners, softeners and the like.

42. (Amended) An injection molding machine in accordance with one Claim 8, characterized in that the mixing arrangement comprises a first layer (192) with a half (152) of a distributor or conveyance channel section (150) and a second layer (191) with another half (153) of the distributor or conveyance channel section (150), and the mixer arrangement includes a mixer (450) located between the first and second layers (192, 191), and the first and second layers (192, 191) are connected together.

REMARKS

The foregoing preliminary amendment is being submitted in order to remove the improper multiple dependencies from the claims as provided by the Annexes to the International Preliminary Examination Report, and to add the required headings to the specification. The Substitute Specification provided herewith incorporates these

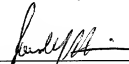
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changes, and the paragraph numbers of the specification have been renumbered based on the changes to the specification. No new material has been added to the application by these amendments.

Prompt examination based on the Substitute Specification is therefore requested.

Respectfully submitted,

Zahoransky et al.

By 
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RJH/tc
Enclosures

MARKED-UP CLAIMS PURSUANT TO 37 CFR §1.121(c)(1)(ii)

3. (Amended) A process in accordance with [one of the Claims 1 or 2] Claim 1, characterized in that the additive material (8) is introduced in a plurality of locations of the distribution arrangement.

4. (Amended) A process in accordance with [one of the Claims 1 to 3] Claim 1, characterized in that the additive material (8) is metered to the injection material by dosages.

5. (Amended) A process in accordance with [one of the Claims 1 to 4] Claim 1, characterized in that the introduction of the additive (8) is blocked during a post-pressure phase of the injection molding process.

6. (Amended) A process in accordance with [one of the Claims 1 to 5] Claim 1, characterized in that the additive (8) is introduced to the injection material at approximately the same temperature as that of the injection material.

8. (Amended) An injection molding machine for the manufacture of injection molded articles, in particular of toothbrush bodies, with an injection molding die (1) and an injection unit (2) mold cavities (5), a distributor channel arrangement (4) with distributor or conveyance channels (150) that carry injection material between the injection unit (2) and individual mold cavities (5) and at least one mixing apparatus (450) for the injection material, and at least one connection for an additive line, [in particular for carrying out the process in accordance with one of claims 1 to 7, characterized in that] wherein the mixing apparatus and the additive line are integrated into the distributor channel arrangement (4, 4a, 100), and

that the mixing apparatus is part of the distributor or conveyance channels (150) of the distributor arrangement (4) and that the additive feed(s) for the additive (8) is (are) connected to the channel main distributor (6) or the channel subdistributor (14) connected to the injection unit (2) and/or in a nozzle connected to the mold cavity.

10. (Amended) An injection molding machine in accordance with [one of the Claims 8 or 9] Claim 8, characterized in that the feed (10) for the additive material (8) can be closed [, preferably by means of shutoff valves (15)].

11. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 10] Claim 8, characterized in that the shutoff valve (15) is designed as a dosage valve for the additive material (8).

12. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 11] Claim 8, characterized in that in a case of a plurality of line connections for additives (8), at least one is connected directly to a mold cavity (5).

13. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 12] Claim 8, characterized in that the mixing apparatus includes at least one mixing chamber (17) formed by a cross-sectional change, preferably by a cross-sectional expansion.

14. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 13] Claim 8, characterized in that a hot channel distributor (100) is provided for handling of melts (101), which, before injection into the mold cavities have been mixed with at least one additive material, and the hot channel distributor (100) includes a melt channel (150) arrangement, in which at least one feed line section (151) is provided for delivery of the additive material (102), an additive material line, with a terminating outlet into the feed line section (151), at least one mixer (300) aligned in a direction of flow, and in that the mixer (300) is formed as a mixing section which includes at least two sections (301, 302), the axes of which are not aligned to coincide with one another.

17. (Amended) An injection molding machine in accordance with [one of the Claims 15 or 16] Claim 15, characterized in that by the use of a plurality of mixers (300) the length and the cross-section of the single mixing sections are made equal for the attainment of balanced flow ratios.

18. (Amended) An injection molding machine in accordance with [one of the Claims 14 to 17] Claim 14, characterized in that the exit opening (303) of the first section (301) is connected to the entry opening (304) of the second section (302) of the two sections (301, 302), by a flow direction reversal fitting (305) of the melt channel (150), wherein the direction of flow in the first section (301) is essentially opposite to the direction of flow in the second section (302).

22. (Amended) An injection molding machine in accordance with [one of the foregoing Claims] Claim 18, characterized in that the first and the second sections (301, 302) are respectively provided as static mixers (450).

26. (Amended) An injection molding machine in accordance with Claim 24 [or 25], characterized in that the adjacent edges (453, 454) of neighboring deflection plates (451, 452) are connected together by spot welding.

34. (Amended) An injection molding machine in accordance with Claim 32 [or 33], characterized in that the needle valve (203) travel is limited to 0.1 to 0.01 mm.

35. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 34] Claim 8, characterized in that within the distribution channel, a separating distance to the entry point of an additive feed (10) from a mold cavity, is determined in consideration of a volume of the article to be produced by injection molding and by an anticipated volume of additive required for the article.

36. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 35] Claim 8, characterized in that a temperature adjustment apparatus is provided for the additive 8, preferably by means of a heating installation placed at the additive material feed (10).

37. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 36] Claim 8, characterized in that one or more distributor channel branches include one or more additive material feeds (10).

38. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 37] Claim 8, characterized in that a plurality of additive feeds (10) are provided in a channel leading to the mold cavities (5) in the direction of flow, and in that the additive feeds (10) can be optionally closed.

39. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 38] Claim 8, characterized in that the entry of the additive feed (10) at the distributor channel is designed as an annular opening.

40. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 39] Claim 8, characterized in that the additive feed (10) includes a feed line (11), a material propelling means, which is preferably formed by a pump (12) as well as an additive storage container (13).

41. (Amended) An injection molding machine in accordance with [one of the Claims 8 to 40] Claim 8, characterized in that the additive includes at least one of the following: color (8), preferably in liquid form, granulates, powder, metal platelets, protective material, reinforcing material, mold release means, chemically active additives such as foam agents for cellular products, hardeners, softeners and the like.

42. (Amended) An injection molding machine in accordance with [one of the claims 8-41] Claim 8, characterized in that the mixing arrangement comprises a first layer (192)

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with a half (152) of a distributor or conveyance channel section (150) and a second layer (191) with another half (153) of the distributor or conveyance channel section (150), and the mixer arrangement includes a mixer (450) located between the first and second layers (192, 191), and the first and second layers (192, 191) are connected together.

SUBSTITUTE SPECIFICATION

[0001] METHOD AND INJECTION MOLDING MACHINE FOR
 PRODUCING INJECTION-MOLDED ARTICLES,
 ESPECIALLY TOOTHBRUSH BODIES OR TOOTHBRUSHES

[0002] BACKGROUND

[0003] The invention relates to a process for the manufacture of injection-molded articles, especially toothbrush bodies or toothbrushes, wherein the molding material is conveyed from a supply container by means of an injection unit, in particular a screw-piston extruder or a similar material delivery means to the mold cavities. Beyond this, the invention relates to an injection molding machine for the carrying out of this process.

[0004] Toothbrushes, particularly in regard to the toothbrush body, have been produced in a multiplicity of colors, generally limited to five different colors. Production in these colors could be executed by the installation of a corresponding number of injection molding machines. However, setting aside the extreme cost factor, such a measure had disadvantages, in that as a rule, different quantities for the toothbrush body lots for each color resulted in no uniform production quota for each machine. Instead, in practice, color changes were undertaken during the production of toothbrush bodies. This again proved to be a complicated matter, very time consuming and caused a poor result in production, which was seen as anything but trivial.

[0005] The various coloring substances were, in one method, mixed dry into the plastic granulate at hand for the toothbrush bodies, and this mixture was then heated in the screw-piston extruder, or a similar delivery system, then liquified and apportioned through a mold-entry and internal cavity connection system for distribution into the individual mold cavities or nests thereof, while the injection procedure was in action. In another method,

liquid coloring material was employed, which if a screw-piston extruder was being used, was fed into the entry chamber thereof.

[0006] If a color change is to be made, then all traces of previous color must be purged from the screw extruder, as well as the delivery channels. This operation is carried out, so that the new color is brought into the system, without stopping the molding of toothbrush bodies until the last remnants of the previous color have been eradicated. This can take as much as an hour and the toothbrush bodies so made, form an unusable product, since they show both the old and the new coloring. Furthermore, an operator's attention is required to monitor the color change of an otherwise automatically running injection molding machine.

[0007] The ensuing costs for such a color change are so great, that this procedure is seldom followed as a matter of practice. On this account, toothbrush bodies of respectively one color are produced on an inventory basis. Where production exceeding the current production needs for toothbrush bodies of one color is concerned, large quantities of toothbrush bodies must therefore be placed in interim inventory, so that, for the subsequent insertion of the bristles, toothbrush bodies of all possible colors are made available in the desired color assortment ratios as called for. For this operation, a corresponding, dedicated area in the factory is necessary. It is also problematic that measures must be taken to avoid, that over a lengthy storage time, a contamination of the toothbrush bodies occurs. This is valid especially in the production of toothbrush bodies from the standpoint of hygienic demands.

[0008] In order to avoid this interim inventory storage, it is certainly possible to forward the produced toothbrush bodies immediately to the insertion of the bristles. However, then an even more circumstantial color sorting following either the insertion operation or the packing could be required.

[0009]

SUMMARY

[0010] Thus, the object of the present invention is to create a process, in which, according to immediate need, a change in production to a different variety, at least in regard to the coloring of the injection molded articles, can be carried out in a short time. Also the possibility should be realized, of simultaneously manufacturing different injection molded items with one injection molding machine. Finally, an injection molding machine for carrying out the process is to be provided.

[0011] For the achievement of this object, insofar as it concerns the process and in accordance with the invention for the manufacture of injection molded items, the molding material is to be combined with at least one additive which is fed into the distribution path of the molding material as this is being delivered to one or more mold cavities. The introduction of the additive is to be at a point in the direction of flow following the injection unit, behind its entry point, and the additive material and the molding material are to be mixed.

[0012] In this way, it becomes possible, with a single injection molding machine, to simultaneously produce different items of injection molding manufacture. This capability substantially reduces the cost and, in many applications, a changeover of the injection molding machine from one item to another becomes a matter of little time and trouble. The basic material issuing from the injection unit on its way to the single or grouped nests of molds receives one or more additives, so that, in accordance with each additive, different items can be simultaneously produced.

[0013] As an example, in the case of an injection molding die with, customarily, a multiplicity of mold cavities, it is possible, by the above described advantage, that toothbrush bodies differing in colors can be injection molded entirely on an as needed basis.

Then in accordance with the required assortment, these bodies can be suitably color grouped as produced in the injection molding machine.

[0014] Additionally, in the case of a possibly foreseen changeover in the production of injection molded items to a different design, such items which may carry the previous additive are essentially smaller and hence a quicker changeover becomes possible. At least the screw-piston type extruder or similar delivery means operation, is isolated from that channel section which contains the additive, for instance coloring material, so the molding material found in the extruder need not be purged. With each new position of the entry point of the color, or the like additive, within the transport path of the molding material as it approaches the mold cavities, the zone containing such additive or coloration is less and thereby, for an individual color change, the requirement for purging also is reduced. By means of mixing the molding material and the additive just after their being joined, the feed of the mix can be done even closer to the respective mold cavity.

[0015] If a multiplicity of additive feed points are foreseen, it is possible that these can be conducted directly into the mold entry opening by means of one feed line. In this case, practically from injection cycle to injection cycle, a change of color could be undertaken, without the necessity of an intermediate purge procedure. Without additional measures for the thorough mixing of color and molding material, it is possible, by direct injection or injection of the color near to the respective mold openings, to bring about desired, colorized formulations, whereby the toothbrush body has no uniform, penetrating color, but exhibits a color pattern. The chromatic or optical appearance can be obtained through the input of several colors or by the addition of color varied in combination with other additives.

[0016] Besides colors, other additive materials, possibly in combinations, can also be added, after the injection unit with respect to the direction of the flow to the molding material within the transport distribution system to the molds. Again, this additive input to

the molding material can be done directly at the mold entry openings. Advantageously, additives are available as colors, preferably liquid colors, powders, metal platelets, reinforcing or supportive material, deformation preventatives, chemically active additives, such as, for instance, a propelling agent, hardening material, softener, or the like.

[0017] Metal platelets can provide a scintillating effect whereby the injection molded product can be varied in its visible appearance, possibly in connection with different colors. As a reinforcing or supporting substance, fiber material, such as glass fibers or carbon fibers can be used, and besides these crushed stone, talcum, or the like can be employed. Aids for extraction of products from molds serve for a better protection for the items made by injection molding, for instance, silicone can be used for this purpose.

[0018] Chemically active additives can be employed for the altering of the properties of the injection material, for instance, to have a desirable effect on the consistency of the material to be molded. Such an additive can also be an activator, which would accelerate the solidification of the molded material. A softener can be added, especially when parts of a toothbrush body are to be provided with an enveloping spray of a rubbery elastic material. An accelerator means would be used, if the injected material comprised two substances.

[0019] In this way, besides reducing time and costs, further advantages emerge from a change in production from one design to another of injected molded articles and to expanded applications of the items.

[0020] The above named or comparable additives, in accordance with the inventive process, permit themselves to be added generally in close proximity to the mold cavities, since they become practically immediately effective. Due to this, making the addition in the supply container for the molding material which entails a long transport path to the mold cavities, or molds, becomes superfluous.

[0021] In a plurality of mold cavities provided in molding dies, these may be connected group-wise by a main channel distributor, or several channel subdistributors to the delivery system for the material to be injected. In this case, the possibility arises, in one embodiment of the invention, that the additive material at least can be supplied in its own channel distribution and subdistribution system.

[0022] If color, in the form of an additive, is input in a main distributor line, then all connected cavities of the molding dies are thus supplied with uniformly colored injection material. Upon the feed of the color into one or more subdistributors, then it is possible, even within the molding plate, to manufacture group-wise, differently colored toothbrush bodies.

[0023] Further the possibility exists, of inserting the additive directly into one or more nozzles, which nozzles are connected to the mold cavity. In this case, in proportion to the number of the available mold cavities, or groups thereof, and dependent upon the number of the desired colors, color changes are seldom necessary, except at considerably extended time periods, and indeed, under certain circumstances, no color change operation may be again necessary. In this way, the problems connected with color change operations do not occur again, or are substantially reduced in scope.

[0024] In accordance with a further development of the invention, the additive is given to the injection material in dosages. By the addition of differing additive quantities, the mixing proportions, especially where color (for instance, white material) is concerned, can be varied. Furthermore, by this method, within a given color, different hues can be achieved. The dosage can be carried out by periodic variation of the additive input and/or by changing the pressure of the additive delivery pressure.

[0025] The invention further relates to an injection molding machine for carrying out the inventive process. This injection molding machine includes an injection molding die,

or dies, which contains an injection mold. The machine also includes an injection unit, in particular with a screw-piston extruder, or similar means of material transport. The function of the extruder is to transport the material to be molded from the injection unit to the distribution or feed channels which lead to the mold cavities. This injection molding machine is characterized, in that at one or more of the distribution channels are connected to one or more feeds for at least one additive. The machine is further characterized in that a respective distribution channel furnished with an additive feed, includes at least one mixing apparatus located, after (with respect to the direction of material flow) its point of connection to the additive feed.

[0026] The advantages essentially achieved with this injection molding machine have already been outlined in connection with the advantages of the above described process. Especially, by the measures available with the inventive injection molding machine, changeovers, for instance color alterations, can be carried out for different embodiments of the injection molded items with essentially less expense and in less time. In the case of injection molding dies containing several groups of mold cavities, as is customary in the manufacture of small brush bodies, especially toothbrush bodies, it is possible that simultaneously, different, especially toothbrush bodies of varied colors, can be produced.

[0027] Further, in a molding die where a multiplicity of mold cavities or groups of mold cavities are present, corresponding to the optional colors or embodiments of the brush bodies, a changeover of said injection molding machine, in the customary concept, becomes superfluous. In addition to this, the characteristics of the injection molded items can be altered by various additives and/or the manufacture improved, in fact, made less complicated. The mixing apparatus serves for a through mixing of the additive material into the basic material to be molded. Also, a good mix can be achieved by means of mixing at the feed point of the additive material close to the mold cavity. Such a mixing chamber has

the advantage, that simple construction therefor is available and with no disturbing downtime.

[0028] A simple embodiment of a mixing apparatus can be provided by a change in the cross-section of a channel, preferably by a mixing chamber formed by an enlargement of the cross-section. Such a mixing chamber has the advantage, that a simple construction is employed and no disturbances can be attributed to the device.

[0029] In order to additionally improve the thorough mixing of additive and injection material, the entry point of the additive feed at the combined feed channel can be designed as an annular type nozzle. By this means, the additive material penetrates the injection material through a multiplicity of perforations, spaced at circumferentially apportioned distances about the additive line termination, thus enabling an intensive mixing at this location. Especially in a combination of one or more successive mixing apparatuses, or, for instance, a mixing chamber, it is possible to obtain a good, intimate mixing of additive and injection material.

[0030] Another advantageous embodiment is so designed that provision is made for a hot distribution channel system for the handling of melted injection material (hereinafter "melt"), the melt, before it is introduced into the mold cavity, is mixed with at least one additive, the distribution system includes at least one melt channel in which at least one feed line section for the entry of additive material opens, provision is made for at least one mixer connected in the direction of material flow, and the mixer is designed as a mixing assembly, which incorporates at least two mixer element sections, the axes of which are not in common alignment.

[0031] The advantage of this embodiment, wherein the design of the mixer is as at least a two-part unit and not as a single straight-line mixing section, lies in that it is now

possible to have an extremely flexible, arrangement of the mixer which adapts itself to the geometry of the hot distribution channel.

[0032] The design of the hot channel distributor as a main distributor brings with it the advantage, that different subdistributors connected to the main distributor can be supplied with melt which is mixed with various additives. For this purpose, a line for one or more additives, which connects into a length of the injection material feed line, and also a mixer in the direction of material flow, are both placed behind a branching leading to one or more subdistributors. In this manner, single subdistributors or groups thereof can be supplied with some flexibility to body melts which are mixed with various additives.

[0033] An even more flexible supply method is possible, if the hot distributor is designed as a subdistributor connected with several hot runner nozzles. With the aid of such a hot channel distributor, individual groups of hot runner nozzles can advantageously be supplied with melts, which melts are already mixed with various additive materials. If more mixers are employed then, advantageously, the length and the cross section of the single mixing stretches are equal. By this means, a balanced flow relationship is achieved, which, in turn, results in a uniform filling and subsequent repressure for each mold cavity.

[0034] In a further advantageous embodiment of the invention, the exit opening of a first section is connected in the direction of the material flow to the intake opening of a second section of the two mixing sections by means of a turn-around fitting. By this configuration, the goal is attained, that the first section provides a flowing material passage in one direction, which is essentially opposite to the flow direction in the second section. The turn around fitting, in this embodiment, allows the non-straight through configuration of the two sections to be realized. By an appropriate angular choice of the turn-around fitting, both sections accommodate themselves to the shape of the distributor and other components present, such as heating wires, or shutoff valves of the hot runner nozzles can

be given consideration of proper placement. If the reverse flow angle of the fitting is 180° , then the length of the mixing section is halved by a loop, so that both channels of the mixing sections are disposed parallel to one another. In this way, an extremely compact hot distributing channel can be designed, which provides a mixer of high capacity, demanding a minimum of space. In another advantageous embodiment, the hot distributor channel can be constructed, using two horizontal planes located one above the other, whereby the first section is found in the lower and first plane and the second section is located in the upper and second plane. This symmetrical arrangement of the two parallel sectional lengths aids in the formation of a balanced channel layout, with equally long flow paths.

[0035] The hot distributor channel can be seen as divided by the two planes, into lower, middle and upper layers, whereby in each layer, grooves are provided and after the soldering of the said layers by vacuum diffusion process, the grooves of respectively matching layers, now form the upper and lower halves of a melt channel.

[0036] Experience has shown it to be of advantage, if the two mix sections are designed as two static mixers, which can effect a high degree of mixing of the melt in a minimum of space. Such static mixers are known from the catalog of *Mixing & Reaction Technology* (1994) of Sulzer Chemtech, GmbH specifically for installation in injection molding machines. These known mixers, however, should only complete the homogenization of the melt with color(s) in addition to a mixing of said melt by the action of an extruder.

[0037] In order to simplify the installation of the static mixer in the hot channel distributor, advantageously, the two static mixer elements can be soldered directly into the melt channel. For this purpose, prior to the soldering of the individual layers, each of the static mixing elements is inserted in one of the melt channel halves, which said half is found in each of the above described layers.

[0038] Preferred static mixer elements encompass respectively, a plurality of screw-shaped, twisted deflection plates, which, in alternate fashion, are arranged sequentially in a left and right sense. Each deflection plate includes two standing edges, perpendicular to the direction of flow, which, respectively, are bound to the adjacent edge of the neighboring deflection plate and are turned, in relation to the neighboring deflection plate, at a specified angle. Such static mixer elements divide the melt and mix non-homogenous streams again with each other. A particularly good dividing effect and mixing action is achieved, when the edges bound to one another are turned to an angle of 90° with each other. The adjacent edges of neighboring deflection plates can be connected by spot welding to one another.

[0039] In a section of a hot feed channel, an end piece of the additive feed can project into and coaxial with the melt channel, whereby an annular opening between the outer wall of the said end piece and the inner wall of the melt channel is formed for the flow of the melt. This advantage allows that the additive be guided into the center stream of the melt flow, which is a favorable situation for the desired uniform mixing of the melt with the additive. The diameter of the end piece of the additive channel can be less than the diameter of that part of the additive channel onto which the said end piece has been attached. This has the favorable effect, that the melt is fortunately hindered from entering into the additive end piece. The additive channel can be connected to a reservoir and a positive pressure pump. The pump impels the additive to be mixed from the reservoir into the end piece of the additive line with an appropriate pressure. The placement of the reservoir and the high pressure pump outside of the hot distributor channel enables a simple maintenance operation as well as a quick and simple additive material switch. Advantageously, the pressure achievable by the high pressure additive pump has a proper relationship to the existing pressure in the melt channel for the injection nozzle.

[0040] The end piece of the additive feed can be closed for metered dosage of the additive material by a needle valve, which, by means of a solenoid or magnetic valve is controllable for intermittent operation. With the aid of the needle valve and of the solenoid, a finely tuned dosage of the additive is possible.

[0041] It has shown itself as advantageous, if the solenoid of the needle valve is activated at a frequency of 30 to 100 cycles per second and the thrust of the needle valve is limited to 0.1 to 0.01 mm.

[0042] BRIEF DESCRIPTION OF THE DRAWINGS

[0043] Additional formulations and embodiments of the invention are made evident in the dependent claims. In the following, the invention, along with its essential particulars, is described in more detail with the aid of the drawings here listed. Schematically shown are:

[0044] Figure 1 is a sectional side view of an injection molding plate with an injection unit,

[0045] Figure 2 is a sectional side view of an injection unit with a connected distribution arrangement and additive feed lines connected to subdistributing channels,

[0046] Figure 3 is an arrangement similar to that shown in Figure 2, but with additive feed lines connected to the nozzles,

[0047] Figure 4 is a view similar to Figure 2 of a distribution channel arrangement with an additive feed connected to a principal distributor,

[0048] Figure 5 is a sectional side view of a distribution channel with an additive feed in the entry area of a nozzle connected to a mold cavity,

[0049] Figure 6 is a schematic view of a hot channel system comprised of a main distributor channel and two subdistributor channels, which are respectively connected to two

groups of five hot runner nozzles, wherein the main distributor is designed as a hot channel distributor in accordance with the invention,

[0050] Figure 7 is a hot channel system as shown in Figure 6, wherein the two subdistributors are designed as hot channel distributors in accordance with the present invention,

[0051] Figure 8 is a cross-section through a subdistributor in accordance with the invention, in which a mixing section with two static mixers is provided,

[0052] Figure 9 is a perspective detail view of one of the two static mixer elements of Figure 8, and

[0053] Figure 10 is a section through the subdistributor of Figure 8 taken along section line V-V.

[0054] DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0055] In the injection molding machine depicted in Figure 1, the injection mold die 1 with the attached injection unit 2 can be seen. With the aid of the injection unit 2, which advantageously includes a materials transport apparatus in the form of a screw-piston extruder, as well as a feed arrangement with hopper 3 for the material to be molded, liquified injection material is transported by means of a distribution channel system 4 to the mold cavities 5. The described feed is carried out in the present case, according to Figure 1, by a main distributor 6, which guides the material to the nozzles 7 at the individual mold cavities 5. Normally, for the manufacture of toothbrush bodies, hot channel plates are provided, wherein the injection material is retained in the feed and distribution channels at its injection temperature. Even the nozzles 7 are designed as so-called hot runner nozzles and are provided with means of heating.

[0056] In the case of the embodiments shown in the figures, additive material will be considered to be color 8 (not shown) and in the further course of the description of the

embodiment, the explanation will take this as a base of the additive material, although other additives exist for the various versions of the brushes or the brush bodies, as has already been discussed in the introductory paragraphs. In the embodiment as shown in Figure 1, the color 8 is introduced inside the main distributor 6, by means of which, the injection material coming from the injection unit 2 for the production of colored toothbrush bodies will be colored. The color feed is done here within the main distributor 6 and thus the coloration proceeds through the main feed line 9 to the individual nozzles 7. The injection material conveyed from the injection unit 2 in the direction of the arrow Pfl mixes itself with the entering color from the color feed 10 of the main feed line 9, whereby in the additional travel distance to the entry openings of the molds, a sufficient mixing of the injection material takes place. Of essential interest in this case, is that the color is not immediately added in the area of the injection unit 2, so that, in case of a necessary change of color, only the colored injection material in the connecting channel length downstream and behind the color feed 10 is retained, which, upon the change of color must be purged by continuous injection molding. Since the feed of the color is carried out first in the main feed channel 9, on this account, the channel volume to be purged is substantially reduced. The color feed 10, which opens into one of the channels of a distributor arrangement 4, 4a, encompasses a feed line 11, a pump 12 as well as a supply tank 13 for the color 8. The pump 12 is advantageously designed both as a transport and dosage metering pump, so that specified quantities of color can be mixed with the injection material.

[0057] At the delivery opening of the color feed 10 into a channel of the distribution arrangement 4, for instance, into the main feed channel 9, a shutoff valve 15 (*refer to Figure 4*) or similar device is provided, so that the feed of color, when required, can be blocked. This could be the situation during the post-pressure phase. For instance, a one way, non-return valve could be provided, which, closes color entry upon sensing a higher pressure in

the distribution channel arrangement than at the color feed 10. The shutoff valve or the like can also be designed as a dosage valve, by means of which a dosed input of color is possible. Besides a continual dosaging, the color can also be injected intermittently, so that the toothbrush body can be produced with a specified color pattern.

[0058] Mention should also be made, that the color is to be delivered at about the same temperature as the injection material, so that opposing, unfavorable properties of the two materials are avoided. For this purpose, a separate temperature apparatus for the color can be provided, or, as another possibility, the heating apparatus for the hot channel feed is also simultaneously coopted to bring the color to the required temperature.

[0059] Figure 2 shows a distribution channel arrangement 4a in which the main distributor 6 is connected to subdistributor 14. In Figure 2, two subdistributors 14 are joined to the main distributor 6. However, it is still possible that even more subdistributors can be installed in planes parallel to the plane of the drawing. An instance of this would be where four parallel planes exist with respectively two subdistributors by means of which sixteen mold openings 5 would be served. As is made clear in Figure 2, the color input feed point 10 in this embodiment is a connection to each subdistributor 14 of the channel 16 issuing from the main distributor 6. This configuration permits two toothbrush bodies of the same color to be injection molded at the same time. In an embodiment with a total of sixteen mold cavities, this would mean that simultaneously, per mold shot, 16 toothbrush bodies with eight different colors could be produced.

[0060] In Figure 4, the color feed lines to the distribution channel arrangement 4 at the main distributor 6 is carried out at the same location as shown in Figure 1, i.e., in the main feed channel 9. In this case, however, two color feeds 10 are provided, with which, alternately, different colors can be bled into the mix. For this purpose, the delivery openings of the color feed 10 can be opened or closed with the aid of a toggle shutoff valve 15. For

an intensive color mixing, is becomes necessary, especially when the color feed 10 is in proximity to the mold inlet opening 5, to provide one or more mixing stations in the feed path.

[0061] Figure 4 also shows mixing chambers 17 located in subordinate channels 16 branching from the main feed channel 9. These mixing chambers 17 are formed by an expansion in the cross-section of the respective branch of channel 16. Such cross-section expansions lead to a condition, in which the injection material flowing through is vortexed and thus better mixed with the therewith infused coloring material. Instead of this especially simple, but effective mixing apparatus, other means of mixing can be provided, for instance a gear pump, possibly without a drive mechanism, or the like.

[0062] As a further measure for a thorough mixing of injection material and the added color, the entrance of the color feed 10, at the distribution channel or the main feed line, can be designed as an annular nozzle. Such an annular nozzle can exhibit a multiplicity of outlet openings on its circumference, so that the color, upon its addition, immediately apportions itself into the cross-section of the injection material, so that, in the shortest path, a thorough mixture is immediately obtained.

[0063] Figure 6, 7 show a melt channel 150 that divides into two branches entering a main distributor 140, each branch eventually reaching another bifurcation into a respective subdistributor 130, to produce thereby, respectively again, two groups 160 of five hot runner nozzles. In the arrangement of Figure 6, the said main distributor 140 becomes part of an inventive hot channel distributor arrangement 100. Into this hot distributor 100 enter two additive lines 200 forming two feed sections 151 which are continuations of hot distributor 150, and onto which respectively a mixer 300 is connected in the direction A of the material flow. The melt channel 150 leads through this said mixer 300 to respectively, a subdistributor 130, which, in turn, is connected to the mentioned five groups of hot runner

nozzles 160. With this arrangement, it is possible that two subdistributors 130 can be supplied with melts 101, with which, in the main distributor 140, different colors 102 are mixed with the injection material.

[0064] A greater flexibility in the mixing of various colors 102, the colors here serving as an example of additives, can be achieved in that, as Figure 7 shows, the subdistributor 130 also becomes part of inventive hot channel distributor 100. For this purpose, the feed delivery line sections 151, into which the additive lines 200 enter, deliver color to the mixer 300 directly before the branch 161 to the individual hot runner nozzles 160. In this way, each group of the hot runner nozzles 160 can be separately supplied with melt 101 which melt is mixed respectively in each case with another color 102, or the same additive.

[0065] In order that balanced flows may be maintained in all parts of the main distributor 140 or the subdistributor 130, it is of advantage, to install equivalent mixers. For instance, where mixers 300 are employed, the length of mixing and cross-sections thereof should be equal.

[0066] For the following embodiment, a liquid coloring means 102 is chosen as the additive color. As Figure 8 shows, a melt channel 150 leads out of the main distributor 140 into the subdistributor 130. In the feed area 151, an endpiece 201 of the additive line 200 discharges into the melt channel 150. An annular opening 202 is formed between the outer wall of said endpiece 201 and the inner wall of the melt channel 150. The melt 101 flows through this annular opening 202 along the endpiece 201. From an opening (not shown) at the tip of the endpiece 201, the color 102 is precisely dosed into the melt 101 with the aid of a needle valve 203. The color 102 is carried along as a thin thread in the center of the melt 101, until the melt 101 and the color 102 enter into the mixer 300. After passing through the mixer 300, the melt 101 and the color 102 are homogeneously mixed and are

conducted to the hot runner nozzles 160, which inject the melt 102 with its mixed in color 101 into the plate containing the mold cavities 5.

[0067] In the embodiment shown in Figure 8, a mixer 300 is shown, which is designed as a mixing length, having two sections, respectively 301, 302. The axes of these two sections are in separate planes. In particular, the exit opening 303 of the first mixer section 301 connects with an intake opening of the second mixer section 302 by means of a 180° turn-around piece, or U-turn fitting, 305, of the melt channel 150. In this manner, the two section pieces 301 and 302 are made parallel to one another. The melt mixture flows through the first section 301 in the direction of arrow B, while the second section 302 carries the flow of melt mixture in the arrow direction C. The through-flow directions B and C of the two section lengths 301 and 302 are, as shown in Figure 8, in opposite directions. The special arrangement of the two parallel section lengths 301 and 302, thus in planes 170, 180, one over the other, allows a symmetrical lead-in of the melt channel 150 to the two hot runner nozzles 160, as shown in Figure 8. Also served by melt channel 150 are two other hot tube nozzles (not shown), which are located symmetrically to the said two hot runner nozzles 160 in the respective sectioning planes. In the embodiment presented in Figure 8, the first section 301 is in the lower plane 170 and the second section 302 is in the upper plane 180 extending immediately above said lower plane. Converse consideration can be given to locate the first section 301 in the upper plane 180 and then to conduct the melt mixture through the second section 302 which lies in the lower plane 170. In this second possibility, the melt 101 with the color 102 would exit the second section 302 directly to the hot runner nozzles 160 similar to the presentation of Figure 8.

[0068] Besides the illustrated embodiments of the invention as shown in Figure 8, naturally other embodiments are possible, in which the two sections 301 and 302 are not in straight through alignment. For instance, the fitting 305 binding the two sections 301 and

302 to make a 180° turn of the melt channel 150 could be employed in such a way that it is twisted through a different angle. In this case, the two sections 301 and 302 do indeed lie respectively in the planes 170, 180, but cease to be parallel, and are disposed at a given angle to one another. This angle could be determined, for instance, to be in accord with the shape of the subdistributor 130, or be aligned to accommodate heating wiring.

[0069] From Figure 8, it may be seen that the two sections 301 and 302 are designed as static mixers 450. The construction of the two static mixers 450, presented in Figure 8 as mixer sections 300, is made evident in Figure 9. Figure 9 shows that such a static mixer as mixer 450 is composed of a plurality of screw shaped deflection plates 451 and 452. In the construction, the alternate left and right oriented deflection plates 451 and 452 are placed sequentially, one behind the other. Each deflection plate 451 possesses two edges 453, standing at right angles to the flow direction D. These edges 453 are respectively joined to the edges 454 of the adjacent deflection plates 452, which likewise stand perpendicular to the direction of flow D. The edges 453 and 454 are turned, in respect to one another, a given angle. In this embodiment, the edges 453 and 454 are joined together at an angle approximating 90°. other angles of said edges are, of course, possible. The adjacent edges 453, 454 of the neighboring deflection plates 451, 452 are connected to one another by spot welding at the binding point 455.

[0070] In Figure 10 it is illustrated that the two static mixers 450 are soldered directly in the melt channel 150, which is made possible by the multi-part construction of the hot channel distributors. This distributor is, as is shown in Figure 10, divided along planes 170, 180 into a lower, a middle, and an upper layer, namely respectively 190, 191, 192. In each layer 190, 191, 192, grooves are provided, which, after the assembly of the layers 190, 191, 192, form the upper and lower halves 152, 153 of the melt channel 150. The binding

together of the layers 190, 191, 192 is done by soldering with the aid of a vacuum diffusion process.

[0071] For the installation, the static mixer 450, is inserted in, respectively, a groove half 152 or 153 before the connection of the layers, 190, 191, 192. The soldering of the static mixer 450 is carried out simultaneously with the soldering of the individual layers 190, 191, 192.

[0072] Obviously, still more static mixers can be provided in parallel arrangement, or beside the illustrated static mixers 450 as these are shown in the Figs. 8 and 10. The modular construction of the hot channel distributor 100, as well as the number of its layers, is dictated by the number of the employed static mixers with consideration given to the assembly principles given above.

[0073] Although, in this embodiment, only static mixer 450 with the deflection plates 451, 452 are presented, naturally, other static mixers, such as, for instance, static mixers with webs can be employed.

[0074] The dosing of the color 102 or a similar additive is done, as again may be further inferred from Figure 8, with the aid of a needle valve 203, which closes and/or opens the endpiece 201. In this operation, the point of the needle valve 203, which is movable, is made to fit into a (not shown in Figure 8) opening of the end piece 201. By means of the longitudinal movement of the needle valve 203, this opening can be closed or opened by the point of said needle valve. Since the high pressure pump in the additive line 200 maintains a permanent pressure of approximately 1000 bar to 1500 bar at the endpiece 201 of said additive line 200, upon the opening of the needle valve 203, a defined amount of the color 102 issues into the melt 101. For the dosaging of the color 102, the said needle valve 203 can be intermittently controlled by a solenoid 204. Together with a retraction spring (not shown) which either opens or closes the valve, the solenoid 204 activates the axial

movement of the needle valve 203. The frequency range, in which the solenoid 204 operates, lies between 30 and 100 cycles/sec. The thrust, by which the needle valve 203 is displaced, is limited to 0.1 to 0.01 mm.

[0075] Figure 3 shows a distribution channel system 4a, somewhat similar to Figure 2, but in which case the additive material feeds 10 are now conducted to each hot runner nozzle 7. Thereby, each mold cavity 5 assigned to each individual nozzle 7 (see Figure 1) can receive an injection, for example, of the chosen color of a toothbrush body. Also, in this case, in the remaining path to the mold cavities 5, an additive as a measure for better mixing between the injection material and the color may be supplied, or the introduction of other additives.

[0076] In the case of the arrangement shown in Figure 5, the feed of the additive material occurs at the end of the hot runner nozzle 7 proximal to the mold cavity 5. In this embodiment, the additive feed line proceeds coaxially inside the nozzle tube and it is here that a needle closure endpiece 18 is provided for the delivery of the additive. To be sure, in the case of direct additive deliver into the mold entry 5, no homogenous thorough mixing is possible. However, this system permits the toothbrush bodies to be especially colorfully formed, whereby mixtures of colors or zones of wavy configurations and the like can be provided. Toothbrush bodies with several color zones can be thus produced. Such coloration effects can also be realized by means of injection material using, for instance, color feed 10 proximal to the mold cavities 5 where the distance from the entrance of the color feed from the adjacent mold cavity 5 is made with consideration of the volume of the item to be molded and the foreseen range of the color thereof. Also, when this is done, in the case of intermittent feed of color, areas of color zones within a toothbrush body can be made.

[0077] Mention should further be made, that by means of the injection unit 2, added injection material itself can already exhibit a basic color, for instance white, so that with additive colors introduced, also combined colors can be achieved. Normally, where basic injection molding material is concerned, the rule is for colorless, mostly transparent substances.

* * *

CLAIMS

What is claimed is:

1. A process for the manufacture of injection molded articles, in particular, for the manufacture of toothbrush bodies or toothbrushes by injection molding, wherein injection material from a raw material supply container (3) is transported by an injection unit (2) or a similar material conveying system to mold cavities (5), and whereby at least one additive is added to the injection material downstream from the injection unit (2) in a flow direction, characterized in that the at least one additive material is introduced by at least one additive feed directly in a distribution or conveyance channel in at least one channel subdistributor and/or a channel main distributor of a distribution channel arrangement and/or in a nozzle connected to a mold cavity, and in that the injection material and the additive material are mixed behind the point of entry of the additive feed (10) in the flow direction.
2. A process in accord with Claim 1, characterized in that the additive material or materials, which can be added to the injection material singly or in combination, comprise color (8), preferably in liquid form, granulates, powder, metal platelets, protection or reinforcement materials, deformation material, and chemically active additive substances such as foaming agents for cellular structure hardening agents, softeners or the like.
3. A process in accordance with one of the Claims 1 or 2, characterized in that the additive material (8) is introduced in a plurality of locations of the distribution arrangement.
4. A process in accordance with one of the Claims 1 to 3, characterized in that the additive material (8) is metered to the injection material by dosages.

5. A process in accordance with one of the Claims 1 to 4, characterized in that the introduction of the additive (8) is blocked during a post-pressure phase of the injection molding process.

6. A process in accordance with one of the Claims 1 to 5, characterized in that the additive (8) is introduced to the injection material at approximately the same temperature as that of the injection material.

7. Process for manufacturing a distribution channel arrangement (4), in particular a hot channel distributor (100) for an injection molding machine, including the steps of:

providing a first layer (192) with a half (152) of a distributor or conveyance channel section (150);

providing a second layer (191) with another half (153) of the distributor or conveyance channel section (150);

providing a mixer arrangement with at least one mixer (450);

locating the mixers (450) in the distribution or conveyance channel (150) between the first and second layers (192, 191); and

connecting the first layer and second layers (191) together.

8. An injection molding machine for the manufacture of injection molded articles, in particular of toothbrush bodies, with an injection molding die (1) and an injection unit (2) mold cavities (5), a distributor channel arrangement (4) with distributor or conveyance channels (150) that carry injection material between the injection unit (2) and individual mold cavities (5) and at least one mixing apparatus (450) for the injection material, and at least one connection for an additive line, in particular for carrying out the process in

accordance with one of claims 1 to 7, characterized in that the mixing apparatus and the additive line are integrated into the distributor channel arrangement (4, 4a, 100), and

that the mixing apparatus is part of the distributor or conveyance channels (150) of the distributor arrangement (4) and that the additive feed(s) for the additive (8) is (are) connected to the channel main distributor (6) or the channel subdistributor (14) connected to the injection unit (2) and/or in a nozzle connected to the mold cavity.

9. An injection molding machine in accordance with Claim 8, characterized in that an additive feed (10) outlet is provided within a nozzle (7) which extends into a mold cavity (5) and in that advantageously, the additive outlet is placed coaxially within the nozzle and terminates at the nozzle outlet end.

10. An injection molding machine in accordance with one of the Claims 8 or 9, characterized in that the feed (10) for the additive material (8) can be closed, preferably by means of shutoff valves (15).

11. An injection molding machine in accordance with one of the Claims 8 to 10, characterized in that the shutoff valve (15) is designed as a dosage valve for the additive material (8).

12. An injection molding machine in accordance with one of the Claims 8 to 11, characterized in that in a case of a plurality of line connections for additives (8), at least one is connected directly to a mold cavity (5).

13. An injection molding machine in accordance with one of the Claims 8 to 12, characterized in that the mixing apparatus includes at least one mixing chamber (17) formed by a cross-sectional change, preferably by a cross-sectional expansion.

14. An injection molding machine in accordance with one of the Claims 8 to 13, characterized in that a hot channel distributor (100) is provided for handling of melts (101), which, before injection into the mold cavities have been mixed with at least one additive material, and the hot channel distributor (100) includes a melt channel (150) arrangement, in which at least one feed line section (151) is provided for delivery of the additive material (102), an additive material line, with a terminating outlet into the feed line section (151), at least one mixer (300) aligned in a direction of flow, and in that the mixer (300) is formed as a mixing section which includes at least two sections (301, 302), the axes of which are not aligned to coincide with one another.

15. An injection molding machine in accordance with Claim 14, characterized in that the hot channel distributor (100) is a connectable main distributor incorporating distributor (140) with a plurality of subdistributors (130), the melt channel (150) of which, branches to the individual subdistributors (130), and said distributor (140) connects to an additive line (200) that exits into the feed line (151) followed by mixer (300) placed in the direction of flow and branches respectively to one or more subdistributors (130) at a connection point (131).

16. An injection molding machine in accordance with Claim 14, characterized in that the hot channel distributor (100), which is provided as a connectable subdistributor with a plurality of hot runner nozzles (160) and includes a subdistributor 130 and the melt channel

(150), branches to the additive line (200) which flows into the feed line section (151) as well as to the mixer (300) which is placed in the direction of flow before a branching (161) leading to the hot runner nozzles (160).

17. An injection molding machine in accordance with one of the Claims 15 or 16, characterized in that by the use of a plurality of mixers (300) the length and the cross-section of the single mixing sections are made equal for the attainment of balanced flow ratios.

18. An injection molding machine in accordance with one of the Claims 14 to 17, characterized in that the exit opening (303) of the first section (301) is connected to the entry opening (304) of the second section (302) of the two sections (301, 302), by a flow direction reversal fitting (305) of the melt channel (150), wherein the direction of flow in the first section (301) is essentially opposite to the direction of flow in the second section (302).

19. An injection molding machine in accordance with Claim 18, characterized in that the exit opening (303) of the first section (301) is connected with the entry opening (304) of the second section (302) by means of a 180° turn-around fitting (305), whereby the two sections (301, 302) of the mixing length are made to be parallel to one another.

20. An injection molding machine in accordance with Claim 19, characterized in that the hot channel distributor (100) is constructed of at least two horizontal planes (170, 180) placed one upon another, whereby the first section (301) is provided in the lower, first plane (170) and the second section ((302) is provided in the upper, second plane (180).

21. An injection molding machine in accordance with Claim 20, characterized in that the hot channel distributor (100) is divided along the two planes (170, 180) into a lower, a middle and an upper layer (190, 191, 192), whereby in each layer, (190, 191, 192) grooves are provided, and whereby, after the soldering of the layers (190, 191, 192) by a vacuum diffusion process, the grooves of adjacent layers (190, 191) and (191, 192) form, respectively, lower and upper halves (152, 153) of the melt channel (150).

22. An injection molding machine in accordance with one of the foregoing Claims, characterized in that the first and the second sections (301, 302) are respectively provided as static mixers (450).

23. An injection molding machine in accordance with Claim 22, characterized in that the two static mixer elements (450) in the lower or the upper half (152, 153) of melt channel (150) are installed directly in the melt channel (150), i.e. are soldered therein.

24. An injection molding machine in accordance with at least one of the Claims 22 and 23, characterized in that the two static mixers elements (450) comprise a plurality of screw shaped, twisting deflection plates (451, 452), which are arranged alternately right and left behind one another, wherein each deflection plate (451) possesses two edges (453) standing at right angles to the material flow direction, which are connected with the respective adjacent edge (454) of the neighboring deflection plate (452), and are turned through a specified angle in relation to said edge (454).

25. An injection molding machine in accordance with Claim 24, characterized in that the edges (453, 454) which are connected together are turned at an angle of 90° from one another.

26. An injection molding machine in accordance with Claim 24 or 25, characterized in that the adjacent edges (453, 454) of neighboring deflection plates (451, 452) are connected together by spot welding.

27. An injection molding machine in accordance with Claim 14, characterized in that in the feed section (151) an endpiece (201) of the additive line (200) penetrates coaxially into the melt channel (150) thereby forming an annular opening (202) between the outer wall of the endpiece (201) and the inner wall of the melt channel (150) to allow flow of melt.

28. An injection molding machine in accordance with Claim 27, characterized in that a diameter of the endpiece (201) of the additive line (200) is smaller than a diameter of the part of the additive line (200) which is connected to the endpiece (201).

29. An injection molding machine in accordance with Claim 14, characterized in that the additive line (200) is connected to a reservoir and a high pressure pump, which pumps the additive material (102) to be mixed out of the said reservoir into the endpiece (201) of the additive line (200) and further into the melt channel (150) at a sufficiently high pressure.

30. An injection molding machine in accordance with Claim 29, characterized in that the pressure generated by the high pressure pump is at least as high as the pressure force in the melt channel (150) at the injection point.

31. An injection molding machine in accordance with Claim 30, characterized in that the pressure generated by the high pressure pump is between 1000 bar and 1500 bar.

32. An injection molding machine in accordance with Claim 29, characterized in that the endpiece (201) of the additive line (200) can be closed by a needle valve (203) for the dosing of the additive (102), and the said needle valve (203) is intermittently controllable.

33. An injection molding machine in accordance with Claim 32, characterized in that a solenoid (204) activates the needle valve (203) at a frequency of 30 to 100 cycles per second.

34. An injection molding machine in accordance with Claim 32 or 33, characterized in that the needle valve (203) travel is limited to 0.1 to 0.01 mm.

35. An injection molding machine in accordance with one of the Claims 8 to 34, characterized in that within the distribution channel, a separating distance to the entry point of an additive feed (10) from a mold cavity, is determined in consideration of a volume of the article to be produced by injection molding and by an anticipated volume of additive required for the article.

36. An injection molding machine in accordance with one of the Claims 8 to 35, characterized in that a temperature adjustment apparatus is provided for the additive 8, preferably by means of a heating installation placed at the additive material feed (10).

37. An injection molding machine in accordance with one of the Claims 8 to 36, characterized in that one or more distributor channel branches include one or more additive material feeds (10).

38. An injection molding machine in accordance with one of the Claims 8 to 37, characterized in that a plurality of additive feeds (10) are provided in a channel leading to the mold cavities (5) in the direction of flow, and in that the additive feeds (10) can be optionally closed.

39. An injection molding machine in accordance with one of the Claims 8 to 38, characterized in that the entry of the additive feed (10) at the distributor channel is designed as an annular opening.

40. An injection molding machine in accordance with one of the Claims 8 to 39, characterized in that the additive feed (10) includes a feed line (11), a material propelling means, which is preferably formed by a pump (12) as well as an additive storage container (13).

41. An injection molding machine in accordance with one of the Claims 8 to 40, characterized in that the additive includes at least one of the following: color (8), preferably in liquid form, granulates, powder, metal platelets, protective material, reinforcing material, mold release means, chemically active additives such as foam agents for cellular products, hardeners, softeners and the like.

42. An injection molding machine in accordance with one of the claims 8-41, characterized in that the mixing arrangement comprises a first layer (192) with a half (152) of a distributor or conveyance channel section (150) and a second layer (191) with another half (153) of the distributor or conveyance channel section (150), and the mixer arrangement includes a mixer (450) located between the first and second layers (192, 191), and the first and second layers (192, 191) are connected together.

ABSTRACT

An injection molding machine for the manufacture of injection molded items, especially toothbrush bodies or toothbrushes, wherein the injection molding machine includes a mold-containing injection die (1) and an injection unit (2), especially with a screw-piston extruder or a similar material transport system. Distribution or transport channels lead from the injection unit (2) forming a distribution channel arrangement (4) to the individual mold cavities (5). One or more feeds (10) are located on the distribution channels and/or the mold cavities for at least one additive, for instance, a liquid color.

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[0001] METHOD AND INJECTION MOLDING MACHINE FOR
PRODUCING INJECTION-MOLDED ARTICLES,
ESPECIALLY TOOTHBRUSH BODIES OR TOOTHBRUSHES.

[0002] BACKGROUND

[0003] The invention relates to a process for the manufacture of injection-molded articles, especially toothbrush bodies or toothbrushes, wherein the molding material is conveyed from a supply container by means of an injection unit, in particular a screw-piston extruder or a similar material delivery means to the mold cavities. Beyond this, the invention relates to an injection molding machine for the carrying out of this process.

[0004] Toothbrushes, particularly in regard to the toothbrush body, have been produced in a multiplicity of colors, generally limited to five different colors. Production in these colors could be executed by the installation of a corresponding number of injection molding machines. However, setting aside the extreme cost factor, such a measure had disadvantages, in that as a rule, different quantities for the toothbrush body lots for each color resulted in no uniform production quota for each machine. Instead, in practice, color changes were undertaken during the production of toothbrush bodies. This again proved to be a complicated matter, very time consuming and caused a poor result in production, which was seen as anything but trivial.

[0005] The various coloring substances were, in one method, mixed dry into the plastic granulate at hand for the toothbrush bodies, and this mixture was then heated in the screw-piston extruder, or a similar delivery system, then liquified and apportioned through a mold-entry and internal cavity connection system for distribution into the individual mold cavities or nests thereof, while the injection procedure was in action. In another method,

liquid coloring material was employed, which if a screw-piston extruder was being used, was fed into the entry chamber thereof.

[0006] If a color change is to be made, then all traces of previous color must be purged from the screw extruder, as well as the delivery channels. This operation is carried out, so that the new color is brought into the system, without stopping the molding of toothbrush bodies until the last remnants of the previous color have been eradicated. This can take as much as an hour and the toothbrush bodies so made, form an unusable product, since they show both the old and the new coloring. Furthermore, an operator's attention is required to monitor the color change of an otherwise automatically running injection molding machine.

[0007] The ensuing costs for such a color change are so great, that this procedure is seldom followed as a matter of practice. On this account, toothbrush bodies of respectively one color are produced on an inventory basis. Where production exceeding the current production needs for toothbrush bodies of one color is concerned, large quantities of toothbrush bodies must therefore be placed in interim inventory, so that, for the subsequent insertion of the bristles, toothbrush bodies of all possible colors are made available in the desired color assortment ratios as called for. For this operation, a corresponding, dedicated area in the factory is necessary. It is also problematic that measures must be taken to avoid, that over a lengthy storage time, a contamination of the toothbrush bodies occurs. This is valid especially in the production of toothbrush bodies from the standpoint of hygienic demands.

[0008] In order to avoid this interim inventory storage, it is certainly possible to forward the produced toothbrush bodies immediately to the insertion of the bristles. However, then an even more circumstantial color sorting following either the insertion operation or the packing could be required.

[0009] Thus, the object of the present invention is to create a process, in which, according to immediate need, a change in production to a different variety, at least in regard to the coloring of the injection molded articles, can be carried out in a short time. Also the possibility should be realized, of simultaneously manufacturing different injection molded items with one injection molding machine. Finally, an injection molding machine for carrying out the process is to be provided.

[0010] For the achievement of this object, insofar as it concerns the process and in accordance with the invention for the manufacture of injection molded items, the molding material is to be combined with at least one additive which is fed into the distribution path of the molding material as this is being delivered to one or more mold cavities. The introduction of the additive is to be at a point in the direction of flow following the injection unit, behind its entry point, and the additive material and the molding material are to be mixed.

[0011] In this way, it becomes possible, with a single injection molding machine, to simultaneously produce different items of injection molding manufacture. This capability substantially reduces the cost and, in many applications, a changeover of the injection molding machine from one item to another becomes a matter of little time and trouble. The basic material issuing from the injection unit on its way to the single or grouped nests of molds receives one or more additives, so that, in accordance with each additive, different items can be simultaneously produced.

[0012] As an example, in the case of an injection molding die with, customarily, a multiplicity of mold cavities, it is possible, by the above described advantage, that toothbrush bodies differing in colors can be injection molded entirely on an as needed basis. Then in accordance with the required assortment, these bodies can be suitably color grouped as produced in the injection molding machine.

[0013] Additionally, in the case of a possibly foreseen changeover in the production of injection molded items to a different design, such items which may carry the previous additive are essentially smaller and hence a quicker changeover becomes possible. At least the screw-piston type extruder or similar delivery means operation, is isolated from that channel section which contains the additive, for instance coloring material, so the molding material found in the extruder need not purged. With each new position of the entry point of the color, or the like additive, within the transport path of the molding material as it approaches the mold cavities, the zone containing such additive or coloration is less and thereby, for an individual color change, the requirement for purging also is reduced. By means of mixing the molding material and the additive just after their being joined, the feed of the mix can be done even closer to the respective mold cavity.

[0014] If a multiplicity additive feed points are foreseen, it is possible that these can be conducted directly into the mold entry opening by means of one feed line. In this case, practically from injection cycle to injection cycle, a change of color could be undertaken, without the necessity of an intermediate purge procedure. Without additional measures for the thorough mixing of color and molding material, it is possible, by direct injection or injection of the color near to the respective mold openings, to bring about desired, colorized formulations, whereby the toothbrush body has no uniform, penetrating color, but exhibits a color pattern. The chromatic or optical appearance can be obtained through the input of several colors or by the addition of color varied in combination with other additives.

[0015] Besides colors, other additive materials, possibly in combinations, can also be added, after the injection unit with respect to the direction of the flow to the molding material within the transport distribution system to the molds. Again, this additive input to the molding material can be done directly at the mold entry openings. Advantageously, additives are available as colors, preferably liquid colors, powders, metal platelets,

reinforcing or supportive material, deformation preventatives, chemically active additives, such as, for instance, a propelling agent, hardening material, softener, or the like.

[0016] Metal platelets can provide a scintillating effect whereby the injection molded product can be varied in its visible appearance, possibly in connection with different colors. As a reinforcing or supporting substance, fiber material. such as glass fibers or carbon fibers can be used, and besides these crushed stone, talcum, or the like can be employed. Aids for extraction of products from molds serve for a better protection for the items made by injection molding, for instance, silicone can be used for this purpose.

[0017] Chemically active additives can be employed for the altering of the properties of the injection material, for instance, to have a desirable effect on the consistency of the material to be molded. Such an additive can also be an activator, which would accelerate the solidification of the molded material. A softener can be added, especially when parts of a toothbrush body are to be provided with an enveloping spray of a rubbery elastic material. An accelerator means would be used, if the injected material comprised two substances.

[0018] In this way, besides reducing time and costs, further advantages emerge from a change in production from one design to another of injected molded articles and to expanded applications of the items.

[0019] The above named or comparable additives, in accordance with the inventive process, permit themselves to be added generally in close proximity to the mold cavities, since they become practically immediately effective. Due to this, making the addition in the supply container for the molding material which entails a long transport path to the mold cavities, or molds, becomes superfluous.

[0020] In a plurality of mold cavities provided in molding dies, these may be connected group-wise by a main channel distributor, or several channel subdistributors to the delivery system for the material to be injected. In this case, the possibility arises, in one

embodiment of the invention, that the additive material at least can be supplied in its own channel distribution and subdistribution system.

[0021] If color, in the form of an additive, is input in a main distributor line, then all connected cavities of the molding dies are thus supplied with uniformly colored injection material. Upon the feed of the color into one or more subdistributors, then it is possible, even within the molding plate, to manufacture group-wise, differently colored toothbrush bodies.

[0022] Further the possibility exists, of inserting the additive directly into one or more nozzles, which nozzles are connected to the mold cavity. In this case, in proportion to the number of the available mold cavities, or groups thereof, and dependent upon the number of the desired colors, color changes are seldom necessary, except at considerably extended time periods, and indeed, under certain circumstances, no color change operation may be again necessary. In this way, the problems connected with color change operations do not occur again, or are substantially reduced in scope.

[0023] In accordance with a further development of the invention, the additive is given to the injection material in dosages. By the addition of differing additive quantities, the mixing proportions, especially where color (for instance, white material) is concerned, can be varied. Furthermore, by this method, within a given color, different hues can be achieved. The dosage can be carried out by periodic variation of the additive input and/or by changing the pressure of the additive delivery pressure.

[0024] The invention further relates to an injection molding machine for carrying out the inventive process. This injection molding machine includes an injection molding die, or dies, which contains an injection mold. The machine also includes an injection unit, in particular with a screw-piston extruder, or similar means of material transport. The function of the extruder is to transport the material to be molded from the injection unit to the

distribution or feed channels which lead to the mold cavities. This injection molding machine is characterized, in that at one or more of the distribution channels are connected to one or more feeds for at least one additive. The machine is further characterized in that a respective distribution channel furnished with an additive feed, includes at least one mixing apparatus located, after (with respect to the direction of material flow) its point of connection to the additive feed.

[0025] The advantages essentially achieved with this injection molding machine have already been outlined in connection with the advantages of the above described process. Especially, by the measures available with the inventive injection molding machine, changeovers, for instance color alterations, can be carried out for different embodiments of the injection molded items with essentially less expense and in less time. In the case of injection molding dies containing several groups of mold cavities, as is customary in the manufacture of small brush bodies, especially toothbrush bodies, it is possible that simultaneously, different, especially toothbrush bodies of varied colors, can be produced.

[0026] Further, in a molding die where a multiplicity of mold cavities or groups of mold cavities are present, corresponding to the optional colors or embodiments of the brush bodies, a changeover of said injection molding machine, in the customary concept, becomes superfluous. In addition to this, the characteristics of the injection molded items can be altered by various additives and/or the manufacture improved, in fact, made less complicated. The mixing apparatus serves for a through mixing of the additive material into the basic material to be molded. Also, a good mix can be achieved by means of mixing at the feed point of the additive material close to the mold cavity. Such a mixing chamber has the advantage, that simple construction therefor is available and with no disturbing downtime.

[0027] A simple embodiment of a mixing apparatus can be provided by a change in the cross-section of a channel, preferably by a mixing chamber formed by an enlargement of the cross-section. Such a mixing chamber has the advantage, that a simple construction is employed and no disturbances can be attributed to the device.

[0028] In order to additionally improve the thorough mixing of additive and injection material, the entry point of the additive feed at the combined feed channel can be designed as an annular type nozzle. By this means, the additive material penetrates the injection material through a multiplicity of perforations, spaced at circumferentially apportioned distances about the additive line termination, thus enabling an intensive mixing at this location. Especially in a combination of one or more successive mixing apparatuses, or, for instance, a mixing chamber, it is possible to obtain a good, intimate mixing of additive and injection material.

[0029] Another advantageous embodiment is so designed that provision is made for a hot distribution channel system for the handling of melted injection material (hereinafter "melt"), the melt, before it is introduced into the mold cavity, is mixed with at least one additive, the distribution system includes at least one melt channel in which at least one feed line section for the entry of additive material opens, provision is made for at least one mixer connected in the direction of material flow, and the mixer is designed as a mixing assembly, which incorporates at least two mixer element sections, the axes of which are not in common alignment.

[0030] The advantage of this embodiment, wherein the design of the mixer is as at least a two-part unit and not as a single straight-line mixing section, lies in that it is now possible to have an extremely flexible, arrangement of the mixer which adapts itself to the geometry of the hot distribution channel.

[0031] The design of the hot channel distributor as a main distributor brings with it the advantage, that different subdistributors connected to the main distributor can be supplied with melt which is mixed with various additives. For this purpose, a line for one or more additives, which connects into a length of the injection material feed line, and also a mixer in the direction of material flow, are both placed behind a branching leading to one or more subdistributors. In this manner, single subdistributors or groups thereof can be supplied with some flexibility to body melts which are mixed with various additives.

[0032] An even more flexible supply method is possible, if the hot distributor is designed as a subdistributor connected with several hot runner nozzles. With the aid of such a hot channel distributor, individual groups of hot runner nozzles can advantageously be supplied with melts, which melts are already mixed with various additive materials. If more mixers are employed then, advantageously, the length and the cross section of the single mixing stretches are equal. By this means, a balanced flow relationship is achieved, which, in turn, results in a uniform filling and subsequent repressure for each mold cavity.

[0033] In a further advantageous embodiment of the invention, the exit opening of a first section is connected in the direction of the material flow to the intake opening of a second section of the two mixing sections by means of a turn-around fitting. By this configuration, the goal is attained, that the first section provides a flowing material passage in one direction, which is essentially opposite to the flow direction in the second section. The turn around fitting, in this embodiment, allows the non-straight through configuration of the two sections to be realized. By an appropriate angular choice of the turn-around fitting, both sections accommodate themselves to the shape of the distributor and other components present, such as heating wires, or shutoff valves of the hot runner nozzles can be given consideration of proper placement. If the reverse flow angle of the fitting is 180°, then the length of the mixing section is halved by a loop, so that both channels of the mixing

sections are disposed parallel to one another. In this way, an extremely compact hot distributing channel can be designed, which provides a mixer of high capacity, demanding a minimum of space. In another advantageous embodiment, the hot distributor channel can be constructed, using two horizontal planes located one above the other, whereby the first section is found in the lower and first plane and the second section is located in the upper and second plane. This symmetrical arrangement of the two parallel sectional lengths aids in the formation of a balanced channel layout, with equally long flow paths.

[0034] The hot distributor channel can be seen as divided by the two planes, into lower, middle and upper layers, whereby in each layer, grooves are provided and after the soldering of the said layers by vacuum diffusion process, the grooves of respectively matching layers, now form the upper and lower halves of a melt channel.

[0035] Experience has shown it to be of advantage, if the two mix sections are designed as two static mixers, which can effect a high degree of mixing of the melt in a minimum of space. Such static mixers are known from the catalog of *Mixing & Reaction Technology* (1994) of Sulzer Chemtech, GmbH specifically for installation in injection molding machines. These known mixers, however, should only complete the homogenization of the melt with color(s) in addition to a mixing of said melt by the action of an extruder.

[0036] In order to simplify the installation of the static mixer in the hot channel distributor, advantageously, the two static mixer elements can be soldered directly into the melt channel. For this purpose, prior to the soldering of the individual layers, each of the static mixing elements is inserted in one of the melt channel halves, which said half is found in each of the above described layers.

[0037] Preferred static mixer elements encompass respectively, a plurality of screw-shaped, twisted deflection plates, which, in alternate fashion, are arranged sequentially in

a left and right sense. Each deflection plate includes two standing edges, perpendicular to the direction of flow, which, respectively, are bound to the adjacent edge of the neighboring deflection plate and are turned, in relation to the neighboring deflection plate, at a specified angle. Such static mixer elements divide the melt and mix non-homogenous streams again with each other. A particularly good dividing effect and mixing action is achieved, when the edges bound to one another are turned to an angle of 90° with each other. The adjacent edges of neighboring deflection plates can be connected by spot welding to one another.

[0038] In a section of a hot feed channel, an end piece of the additive feed can project into and coaxial with the melt channel, whereby an annular opening between the outer wall of the said end piece and the inner wall of the melt channel is formed for the flow of the melt. This advantage allows that the additive be guided into the center stream of the melt flow, which is a favorable situation for the desired uniform mixing of the melt with the additive. The diameter of the end piece of the additive channel can be less than the diameter of that part of the additive channel onto which the said end piece has been attached. This has the favorable effect, that the melt is fortunately hindered from entering into the additive end piece. The additive channel can be connected to a reservoir and a positive pressure pump. The pump impels the additive to be mixed from the reservoir into the end piece of the additive line with an appropriate pressure. The placement of the reservoir and the high pressure pump outside of the hot distributor channel enables a simple maintenance operation as well as a quick and simple additive material switch. Advantageously, the pressure achievable by the high pressure additive pump has a proper relationship to the existing pressure in the melt channel for the injection nozzle.

[0039] The end piece of the additive feed can be closed for metered dosage of the additive material by a needle valve, which, by means of a solenoid or magnetic valve is

controllable for intermittent operation. With the aid of the needle valve and of the solenoid, a finely tuned dosage of the additive is possible.

[0040] It has shown itself as advantageous, if the solenoid of the needle valve is activated at a frequency of 30 to 100 cycles per second and the thrust of the needle valve is limited to 0.1 to 0.01 mm.

[0041] Additional formulations and embodiments of the invention are made evident in the dependent claims. In the following, the invention, along with its essential particulars, is described in more detail with the aid of the drawings here listed. Schematically shown are:

[0042] Figure 1 is a sectional side view of an injection molding plate with an injection unit,

[0043] Figure 2 is a sectional side view of an injection unit with a connected distribution arrangement and additive feed lines connected to subdistributing channels,

[0044] Figure 3 is an arrangement similar to that shown in Figure 2, but with additive feed lines connected to the nozzles,

[0045] Figure 4 is a view similar to Figure 2 of a distribution channel arrangement with an additive feed connected to a principal distributor,

[0046] Figure 5 is a sectional side view of a distribution channel with an additive feed in the entry area of a nozzle connected to a mold cavity,

[0047] Figure 6 is a schematic view of a hot channel system comprised of a main distributor channel and two subdistributor channels, which are respectively connected to two groups of five hot runner nozzles, wherein the main distributor is designed as a hot channel distributor in accordance with the invention,

[0048] Figure 7 is a hot channel system as shown in Figure 6, wherein the two subdistributors are designed as hot channel distributors in accordance with the present invention,

[0049] Figure 8 is a cross-section through a subdistributor in accordance with the invention, in which a mixing section with two static mixers is provided,

[0050] Figure 9 is a perspective detail view of one of the two static mixer elements of Figure 8, and

[0051] Figure 10 is a section through the subdistributor of Figure 8 taken along section line V-V.

[0052] In the injection molding machine depicted in Figure 1, the injection mold die 1 with the attached injection unit 2 can be seen. With the aid of the injection unit 2, which advantageously includes a materials transport apparatus in the form of a screw-piston extruder, as well as a feed arrangement with hopper 3 for the material to be molded, liquified injection material is transported by means of a distribution channel system 4 to the mold cavities 5. The described feed is carried out in the present case, according to Figure 1, by a main distributor 6, which guides the material to the nozzles 7 at the individual mold cavities 5. Normally, for the manufacture of toothbrush bodies, hot channel plates are provided, wherein the injection material is retained in the feed and distribution channels at its injection temperature. Even the nozzles 7 are designed as so-called hot runner nozzles and are provided with means of heating.

[0053] In the case of the embodiments shown in the figures, additive material will be considered to be color 8 (not shown) and in the further course of the description of the embodiment, the explanation will take this as a base of the additive material, although other additives exist for the various versions of the brushes or the brush bodies, as has already been discussed in the introductory paragraphs. In the embodiment as shown in Figure 1, the

color 8 is introduced inside the main distributor 6, by means of which, the injection material coming from the injection unit 2 for the production of colored toothbrush bodies will be colored. The color feed is done here within the main distributor 6 and thus the coloration proceeds through the main feed line 9 to the individual nozzles 7. The injection material conveyed from the injection unit 2 in the direction of the arrow Pf1 mixes itself with the entering color from the color feed 10 of the main feed line 9, whereby in the additional travel distance to the entry openings of the molds, a sufficient mixing of the injection material takes place. Of essential interest in this case, is that the color is not immediately added in the area of the injection unit 2, so that, in case of a necessary change of color, only the colored injection material in the connecting channel length downstream and behind the color feed 10 is retained, which, upon the change of color must be purged by continuous injection molding. Since the feed of the color is carried out first in the main feed channel 9, on this account, the channel volume to be purged is substantially reduced. The color feed 10, which opens into one of the channels of a distributor arrangement 4, 4a, encompasses a feed line 11, a pump 12 as well as a supply tank 13 for the color 8. The pump 12 is advantageously designed both as a transport and dosage metering pump, so that specified quantities of color can be mixed with the injection material.

[0054] At the delivery opening of the color feed 10 into a channel of the distribution arrangement 4, for instance, into the main feed channel 9, a shutoff valve 15 (*refer to Figure 4*) or similar device is provided, so that the feed of color, when required, can be blocked. This could be the situation during the post-pressure phase. For instance, a one way, non-return valve could be provided, which, closes color entry upon sensing a higher pressure in the distribution channel arrangement than at the color feed 10. The shutoff valve or the like can also be designed as a dosage valve, by means of which a dosed input of color is possible.

Besides a continual dosaging, the color can also be injected intermittently, so that the toothbrush body can be produced with a specified color pattern.

[0055] Mention should also be made, that the color is to be delivered at about the same temperature as the injection material, so that opposing, unfavorable properties of the two materials are avoided. For this purpose, a separate temperature apparatus for the color can be provided, or, as another possibility, the heating apparatus for the hot channel feed is also simultaneously coopted to bring the color to the required temperature.

[0056] Figure 2 shows a distribution channel arrangement 4a in which the main distributor 6 is connected to subdistributor 14. In Figure 2, two subdistributors 14 are joined to the main distributor 6. However, it is still possible that even more subdistributors can be installed in planes parallel to the plane of the drawing. An instance of this would be where four parallel planes exist with respectively two subdistributors by means of which sixteen mold openings 5 would be served. As is made clear in Figure 2, the color input feed point 10 in this embodiment is a connection to each subdistributor 14 of the channel 16 issuing from the main distributor 6. This configuration permits two toothbrush bodies of the same color to be injection molded at the same time. In an embodiment with a total of sixteen mold cavities, this would mean that simultaneously, per mold shot, 16 toothbrush bodies with eight different colors could be produced.

[0057] In Figure 4, the color feed lines to the distribution channel arrangement 4 at the main distributor 6 is carried out at the same location as shown in Figure 1, i.e., in the main feed channel 9. In this case, however, two color feeds 10 are provided, with which, alternately, different colors can be bled into the mix. For this purpose, the delivery openings of the color feed 10 can be opened or closed with the aid of a toggle shutoff valve 15. For an intensive color mixing, is becomes necessary, especially when the color feed 10 is in

proximity to the mold inlet opening 5, to provide one or more mixing stations in the feed path.

[0058] Figure 4 also shows mixing chambers 17 located in subordinate channels 16 branching from the main feed channel 9. These mixing chambers 17 are formed by an expansion in the cross-section of the respective branch of channel 16. Such cross-section expansions lead to a condition, in which the injection material flowing through is vortexed and thus better mixed with the therewith infused coloring material. Instead of this especially simple, but effective mixing apparatus, other means of mixing can be provided, for instance a gear pump, possibly without a drive mechanism, or the like.

[0059] As a further measure for a thorough mixing of injection material and the added color, the entrance of the color feed 10, at the distribution channel or the main feed line, can be designed as an annular nozzle. Such an annular nozzle can exhibit a multiplicity of outlet openings on its circumference, so that the color, upon its addition, immediately apportions itself into the cross-section of the injection material, so that, in the shortest path, a thorough mixture is immediately obtained.

[0060] Figure 6, 7 show a melt channel 150 that divides into two branches entering a main distributor 140, each branch eventually reaching another bifurcation into a respective subdistributor 130, to produce thereby, respectively again, two groups 160 of five hot runner nozzles. In the arrangement of Figure 6, the said main distributor 140 becomes part of an inventive hot channel distributor arrangement 100. Into this hot distributor 100 enter two additive lines 200 forming two feed sections 151 which are continuations of hot distributor 150, and onto which respectively a mixer 300 is connected in the direction A of the material flow. The melt channel 150 leads through this said mixer 300 to respectively, a subdistributor 130, which, in turn, is connected to the mentioned five groups of hot runner nozzles 160. With this arrangement, it is possible that two subdistributors 130 can be

supplied with melts 101, with which, in the main distributor 140, different colors 102 are mixed with the injection material.

[0061] A greater flexibility in the mixing of various colors 102, the colors here serving as an example of additives, can be achieved in that, as Figure 7 shows, the subdistributor 130 also becomes part of inventive hot channel distributor 100. For this purpose, the feed delivery line sections 151, into which the additive lines 200 enter, deliver color to the mixer 300 directly before the branch 161 to the individual hot runner nozzles 160. In this way, each group of the hot runner nozzles 160 can be separately supplied with melt 101 which melt is mixed respectively in each case with another color 102, or the same additive.

[0062] In order that balanced flows may be maintained in all parts of the main distributor 140 or the subdistributor 130, it is of advantage, to install equivalent mixers. For instance, where mixers 300 are employed, the length of mixing and cross-sections thereof should be equal.

[0063] For the following embodiment, a liquid coloring means 102 is chosen as the additive color. As Figure 8 shows, a melt channel 150 leads out of the main distributor 140 into the subdistributor 130. In the feed area 151, an endpiece 201 of the additive line 200 discharges into the melt channel 150. An annular opening 202 is formed between the outer wall of said endpiece 201 and the inner wall of the melt channel 150. The melt 101 flows through this annular opening 202 along the endpiece 201. From an opening (not shown) at the tip of the endpiece 201, the color 102 is precisely dosed into the melt 101 with the aid of a needle valve 203. The color 102 is carried along as a thin thread in the center of the melt 101, until the melt 101 and the color 102 enter into the mixer 300. After passing through the mixer 300, the melt 101 and the color 102 are homogeneously mixed and are

conducted to the hot runner nozzles 160, which inject the melt 102 with its mixed in color 101 into the plate containing the mold cavities 5.

[0064] In the embodiment shown in Figure 8, a mixer 300 is shown, which is designed as a mixing length, having two sections, respectively 301, 302. The axes of these two sections are in separate planes. In particular, the exit opening 303 of the first mixer section 301 connects with an intake opening of the second mixer section 302 by means of a 180° turn-around piece, or U-turn fitting, 305, of the melt channel 150. In this manner, the two section pieces 301 and 302 are made parallel to one another. The melt mixture flows through the first section 301 in the direction of arrow B, while the second section 302 carries the flow of melt mixture in the arrow direction C. The through-flow directions B and C of the two section lengths 301 and 302 are, as shown in Figure 8, in opposite directions. The special arrangement of the two parallel section lengths 301 and 302, thus in planes 170, 180, one over the other, allows a symmetrical lead-in of the melt channel 150 to the two hot runner nozzles 160, as shown in Figure 8. Also served by melt channel 150 are two other hot tube nozzles (not shown), which are located symmetrically to the said two hot runner nozzles 160 in the respective sectioning planes. In the embodiment presented in Figure 8, the first section 301 is in the lower plane 170 and the second section 302 is in the upper plane 180 extending immediately above said lower plane. Converse consideration can be given to locate the first section 301 in the upper plane 180 and then to conduct the melt mixture through the second section 302 which lies in the lower plane 170. In this second possibility, the melt 101 with the color 102 would exit the second section 302 directly to the hot runner nozzles 160 similar to the presentation of Figure 8.

[0065] Besides the illustrated embodiments of the invention as shown in Figure 8, naturally other embodiments are possible, in which the two sections 301 and 302 are not in straight through alignment. For instance, the fitting 305 binding the two sections 301 and

302 to make a 180° turn of the melt channel 150 could be employed in such a way that it is twisted through a different angle. In this case, the two sections 301 and 302 do indeed lie respectively in the planes 170, 180, but cease to be parallel, and are disposed at a given angle to one another. This angle could be determined, for instance, to be in accord with the shape of the subdistributor 130, or be aligned to accommodate heating wiring.

[0066] From Figure 8, it may be seen that the two sections 301 and 302 are designed as static mixers 450. The construction of the two static mixers 450, presented in Figure 8 as mixer sections 300, is made evident in Figure 9. Figure 9 shows that such a static mixer as mixer 450 is composed of a plurality of screw shaped deflection plates 451 and 452. In the construction, the alternate left and right oriented deflection plates 451 and 452 are placed sequentially, one behind the other. Each deflection plate 451 possesses two edges 453, standing at right angles to the flow direction D. These edges 453 are respectively joined to the edges 454 of the adjacent deflection plates 452, which likewise stand perpendicular to the direction of flow D. The edges 453 and 454 are turned, in respect to one another, a given angle. In this embodiment, the edges 453 and 454 are joined together at an angle approximating 90°. other angles of said edges are, of course, possible. The adjacent edges 453, 454 of the neighboring deflection plates 451, 452 are connected to one another by spot welding at the binding point 455.

[0067] In Figure 10 it is illustrated that the two static mixers 450 are soldered directly in the melt channel 150, which is made possible by the multi-part construction of the hot channel distributors. This distributor is, as is shown in Figure 10, divided along planes 170, 180 into a lower, a middle, and an upper layer, namely respectively 190, 191, 192. In each layer 190, 191, 192, grooves are provided, which, after the assembly of the layers 190, 191, 192, form the upper and lower halves 152, 153 of the melt channel 150. The binding

together of the layers 190, 191, 192 is done by soldering with the aid of a vacuum diffusion process.

[0068] For the installation, the static mixer 450, is inserted in, respectively, a groove half 152 or 153 before the connection of the layers, 190, 191, 192. The soldering of the static mixer 450 is carried out simultaneously with the soldering of the individual layers 190, 191, 192.

[0069] Obviously, still more static mixers can be provided in parallel arrangement, or beside the illustrated static mixers 450 as these are shown in the Figs. 8 and 10. The modular construction of the hot channel distributor 100, as well as the number of its layers, is dictated by the number of the employed static mixers with consideration given to the assembly principles given above.

[0070] Although, in this embodiment, only static mixer 450 with the deflection plates 451, 452 are presented, naturally, other static mixers, such as, for instance, static mixers with webs can be employed.

[0071] The dosing of the color 102 or a similar additive is done, as again may be further inferred from Figure 8, with the aid of a needle valve 203, which closes and/or opens the endpiece 201. In this operation, the point of the needle valve 203, which is movable, is made to fit into a (not shown in Figure 8) opening of the end piece 201. By means of the longitudinal movement of the needle valve 203, this opening can be closed or opened by the point of said needle valve. Since the high pressure pump in the additive line 200 maintains a permanent pressure of approximately 1000 bar to 1500 bar at the endpiece 201 of said additive line 200, upon the opening of the needle valve 203, a defined amount of the color 102 issues into the melt 101. For the dosaging of the color 102, the said needle valve 203 can be intermittently controlled by a solenoid 204. Together with a retraction spring (not shown) which either opens or closes the valve, the solenoid 204 activates the axial

movement of the needle valve 203. The frequency range, in which the solenoid 204 operates, lies between 30 and 100 cycles/sec. The thrust, by which the needle valve 203 is displaced, is limited to

0.1 to 0.01 mm.

[0072] Figure 3 shows a distribution channel system 4a, somewhat similar to Figure 2, but in which case the additive material feeds 10 are now conducted to each hot runner nozzle 7. Thereby, each mold cavity 5 assigned to each individual nozzle 7 (see Figure 1) can receive an injection, for example, of the chosen color of a toothbrush body. Also, in this case, in the remaining path to the mold cavities 5, an additive as a measure for better mixing between the injection material and the color may be supplied, or the introduction of other additives.

[0073] In the case of the arrangement shown in Figure 5, the feed of the additive material occurs at the end of the hot runner nozzle 7 proximal to the mold cavity 5. In this embodiment, the additive feed line proceeds coaxially inside the nozzle tube and it is here that a needle closure endpiece 18 is provided for the delivery of the additive. To be sure, in the case of direct additive deliver into the mold entry 5, no homogenous thorough mixing is possible. However, this system permits the toothbrush bodies to be especially colorfully formed, whereby mixtures of colors or zones of wavy configurations and the like can be provided. Toothbrush bodies with several color zones can be thus produced. Such coloration effects can also be realized by means of injection material using, for instance, color feed 10 proximal to the mold cavities 5 where the distance from the entrance of the color feed from the adjacent mold cavity 5 is made with consideration of the volume of the item to be molded and the foreseen range of the color thereof. Also, when this is done, in the case of intermittent feed of color, areas of color zones within a toothbrush body can be made.

[0074] Mention should further be made, that by means of the injection unit 2, added injection material itself can already exhibit a basic color, for instance white, so that with additive colors introduced, also combined colors can be achieved. Normally, where basic injection molding material is concerned, the rule is for colorless, mostly transparent substances.

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Translation of Annexes to
International Preliminary Examination Report
for PCT/EP98/08509

CLAIMS

What is claimed is:

1. A process for the manufacture of injection molded articles, in particular, for the manufacture of toothbrush bodies or toothbrushes by injection molding, wherein injection material from a raw material supply container (3) is transported by an injection unit (2) or a similar material conveying system to mold cavities (5), and whereby at least one additive is added to the injection material downstream from the injection unit (2) in a flow direction, characterized in that the at least one additive material is introduced by at least one additive feed directly in a distribution or conveyance channel in at least one channel subdistributor and/or a channel main distributor of a distribution channel arrangement and/or in a nozzle connected to a mold cavity, and in that the injection material and the additive material are mixed behind the point of entry of the additive feed (10) in the flow direction.
2. A process in accord with Claim 1, characterized in that the additive material or materials, which can be added to the injection material singly or in combination, comprise color (8), preferably in liquid form, granulates, powder, metal platelets, protection or reinforcement materials, deformation material, and chemically active additive substances such as foaming agents for cellular structure hardening agents, softeners or the like.
3. A process in accordance with one of the Claims 1 or 2, characterized in that the additive material (8) is introduced in a plurality of locations of the distribution arrangement.

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4. A process in accordance with one of the Claims 1 to 3, characterized in that the additive material (8) is metered to the injection material by dosages.

5. A process in accordance with one of the Claims 1 to 4, characterized in that the introduction of the additive (8) is blocked during a post-pressure phase of the injection molding process.

6. A process in accordance with one of the Claims 1 to 5, characterized in that the additive (8) is introduced to the injection material at approximately the same temperature as that of the injection material.

7. Process for manufacturing a distribution channel arrangement (4), in particular a hot channel distributor (100) for an injection molding machine, including the steps of:

providing a first layer (192) with a half (152) of a distributor or conveyance channel section (150);

providing a second layer (191) with another half (153) of the distributor or conveyance channel section (150);

providing a mixer arrangement with at least one mixer (450);

locating the mixers (450) in the distribution or conveyance channel (150) between the first and second layers (192, 191); and

connecting the first layer and second layers (191) together.

8. An injection molding machine for the manufacture of injection molded articles, in particular of toothbrush bodies, with an injection molding die (1) and an injection unit (2) mold cavities (5), a distributor channel arrangement (4) with distributor or conveyance

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channels (150) that carry injection material between the injection unit (2) and individual mold cavities (5) and at least one mixing apparatus (450) for the injection material, and at least one connection for an additive line, in particular for carrying out the process in accordance with one of claims 1 to 7, characterized in that the mixing apparatus and the additive line are integrated into the distributor channel arrangement (4, 4a, 100), and

that the mixing apparatus is part of the distributor or conveyance channels (150) of the distributor arrangement (4) and that the additive feed(s) for the additive (8) is (are) connected to the channel main distributor (6) or the channel subdistributor (14) connected to the injection unit (2) and/or in a nozzle connected to the mold cavity.

9. An injection molding machine in accordance with Claim 8, characterized in that an additive feed (10) outlet is provided within a nozzle (7) which extends into a mold cavity (5) and in that advantageously, the additive outlet is placed coaxially within the nozzle and terminates at the nozzle outlet end.

10. An injection molding machine in accordance with one of the Claims 8 or 9, characterized in that the feed (10) for the additive material (8) can be closed, preferably by means of shutoff valves (15).

11. An injection molding machine in accordance with one of the Claims 8 to 10, characterized in that the shutoff valve (15) is designed as a dosage valve for the additive material (8).

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12. An injection molding machine in accordance with one of the Claims 8 to 11, characterized in that in a case of a plurality of line connections for additives (8), at least one is connected directly to a mold cavity (5).

13. An injection molding machine in accordance with one of the Claims 8 to 12, characterized in that the mixing apparatus includes at least one mixing chamber (17) formed by a cross-sectional change, preferably by a cross-sectional expansion.

14. An injection molding machine in accordance with one of the Claims 8 to 13, characterized in that a hot channel distributor (100) is provided for handling of melts (101), which, before injection into the mold cavities have been mixed with at least one additive material, and the hot channel distributor (100) includes a melt channel (150) arrangement, in which at least one feed line section (151) is provided for delivery of the additive material (102), an additive material line, with a terminating outlet into the feed line section (151), at least one mixer (300) aligned in a direction of flow, and in that the mixer (300) is formed as a mixing section which includes at least two sections (301, 302), the axes of which are not aligned to coincide with one another.

15. An injection molding machine in accordance with Claim 14, characterized in that the hot channel distributor (100) is a connectable main distributor incorporating distributor (140) with a plurality of subdistributors (130), the melt channel (150) of which, branches to the individual subdistributors (130), and said distributor (140) connects to an additive line (200) that exits into the feed line (151) followed by mixer (300) placed in the direction of flow and branches respectively to one or more subdistributors (130) at a connection point (131).

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16. An injection molding machine in accordance with Claim 14, characterized in that the hot channel distributor (100), which is provided as a connectable subdistributor with a plurality of hot runner nozzles (160) and includes a subdistributor 130 and the melt channel (150), branches to the additive line (200) which flows into the feed line section (151) as well as to the mixer (300) which is placed in the direction of flow before a branching (161) leading to the hot runner nozzles (160).

17. An injection molding machine in accordance with one of the Claims 15 or 16, characterized in that by the use of a plurality of mixers (300) the length and the cross-section of the single mixing sections are made equal for the attainment of balanced flow ratios.

18. An injection molding machine in accordance with one of the Claims 14 to 17, characterized in that the exit opening (303) of the first section (301) is connected to the entry opening (304) of the second section (302) of the two sections (301, 302), by a flow direction reversal fitting (305) of the melt channel (150), wherein the direction of flow in the first section (301) is essentially opposite to the direction of flow in the second section (302).

19. An injection molding machine in accordance with Claim 18, characterized in that the exit opening (303) of the first section (301) is connected with the entry opening (304) of the second section (302) by means of a 180° turn-around fitting (305), whereby the two sections (301, 302) of the mixing length are made to be parallel to one another.

20. An injection molding machine in accordance with Claim 19, characterized in that the hot channel distributor (100) is constructed of at least two horizontal planes (170, 180)

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placed one upon another, whereby the first section (301) is provided in the lower, first plane (170) and the second section ((302) is provided in the upper, second plane (180).

21. An injection molding machine in accordance with Claim 20, characterized in that the hot channel distributor (100) is divided along the two planes (170, 180) into a lower, a middle and an upper layer (190, 191, 192), whereby in each layer, (190, 191, 192) grooves are provided, and whereby, after the soldering of the layers (190, 191, 192) by a vacuum diffusion process, the grooves of adjacent layers (190, 191) and (191, 192) form, respectively, lower and upper halves (152, 153) of the melt channel (150).

22. An injection molding machine in accordance with one of the foregoing Claims, characterized in that the first and the second sections (301, 302) are respectively provided as static mixers (450).

23. An injection molding machine in accordance with Claim 22, characterized in that the two static mixer elements (450) in the lower or the upper half (152, 153) of melt channel (150) are installed directly in the melt channel (150), i.e. are soldered therein.

24. An injection molding machine in accordance with at least one of the Claims 22 and 23, characterized in that the two static mixers elements (450) comprise a plurality of screw shaped, twisting deflection plates (451, 452), which are arranged alternately right and left behind one another, wherein each deflection plate (451) possesses two edges (453) standing at right angles to the material flow direction, which are connected with the respective adjacent edge (454) of the neighboring deflection plate (452), and are turned through a specified angle in relation to said edge (454).

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25. An injection molding machine in accordance with Claim 24, characterized in that the edges (453, 454) which are connected together are turned at an angle of 90° from one another.
26. An injection molding machine in accordance with Claim 24 or 25, characterized in that the adjacent edges (453, 454) of neighboring deflection plates (451, 452) are connected together by spot welding.
27. An injection molding machine in accordance with Claim 14, characterized in that in the feed section (151) an endpiece (201) of the additive line (200) penetrates coaxially into the melt channel (150) thereby forming an annular opening (202) between the outer wall of the endpiece (201) and the inner wall of the melt channel (150) to allow flow of melt.
28. An injection molding machine in accordance with Claim 27, characterized in that a diameter of the endpiece (201) of the additive line (200) is smaller than a diameter of the part of the additive line (200) which is connected to the endpiece (201).
29. An injection molding machine in accordance with Claim 14, characterized in that the additive line (200) is connected to a reservoir and a high pressure pump, which pumps the additive material (102) to be mixed out of the said reservoir into the endpiece (201) of the additive line (200) and further into the melt channel (150) at a sufficiently high pressure.
30. An injection molding machine in accordance with Claim 29, characterized in that the pressure generated by the high pressure pump is at least as high as the pressure force in the melt channel (150) at the injection point.

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31. An injection molding machine in accordance with Claim 30, characterized in that the pressure generated by the high pressure pump is between 1000 bar and 1500 bar.

32. An injection molding machine in accordance with Claim 29, characterized in that the endpiece (201) of the additive line (200) can be closed by a needle valve (203) for the dosing of the additive (102), and the said needle valve (203) is intermittently controllable.

33. An injection molding machine in accordance with Claim 32, characterized in that a solenoid (204) activates the needle valve (203) at a frequency of 30 to 100 cycles per second.

34. An injection molding machine in accordance with Claim 32 or 33, characterized in that the needle valve (203) travel is limited to 0.1 to 0.01 mm.

35. An injection molding machine in accordance with one of the Claims 8 to 34, characterized in that within the distribution channel, a separating distance to the entry point of an additive feed (10) from a mold cavity, is determined in consideration of a volume of the article to be produced by injection molding and by an anticipated volume of additive required for the article.

36. An injection molding machine in accordance with one of the Claims 8 to 35, characterized in that a temperature adjustment apparatus is provided for the additive 8, preferably by means of a heating installation placed at the additive material feed (10).

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37. An injection molding machine in accordance with one of the Claims 8 to 36, characterized in that one or more distributor channel branches include one or more additive material feeds (10).

38. An injection molding machine in accordance with one of the Claims 8 to 37, characterized in that a plurality of additive feeds (10) are provided in a channel leading to the mold cavities (5) in the direction of flow, and in that the additive feeds (10) can be optionally closed.

39. An injection molding machine in accordance with one of the Claims 8 to 38, characterized in that the entry of the additive feed (10) at the distributor channel is designed as an annular opening.

40. An injection molding machine in accordance with one of the Claims 8 to 39, characterized in that the additive feed (10) includes a feed line (11), a material propelling means, which is preferably formed by a pump (12) as well as an additive storage container (13).

41. An injection molding machine in accordance with one of the Claims 8 to 40, characterized in that the additive includes at least one of the following: color (8), preferably in liquid form, granulates, powder, metal platelets, protective material, reinforcing material, mold release means, chemically active additives such as foam agents for cellular products, hardeners, softeners and the like.

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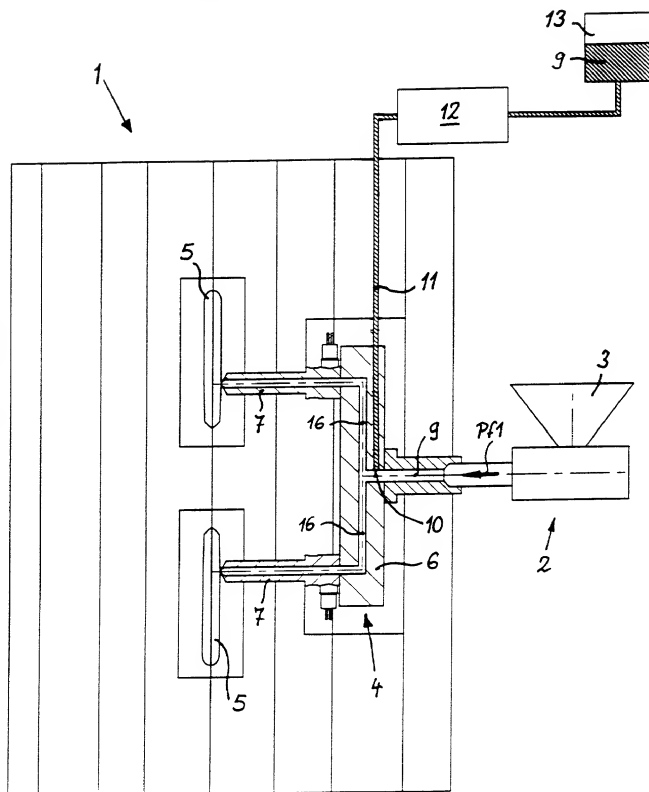
42. An injection molding machine in accordance with one of the claims 8-41, characterized in that the mixing arrangement comprises a first layer (192) with a half (152) of a distributor or conveyance channel section (150) and a second layer (191) with another half (153) of the distributor or conveyance channel section (150), and the mixer arrangement includes a mixer (450) located between the first and second layers (192, 191), and the first and second layers (192, 191) are connected together.

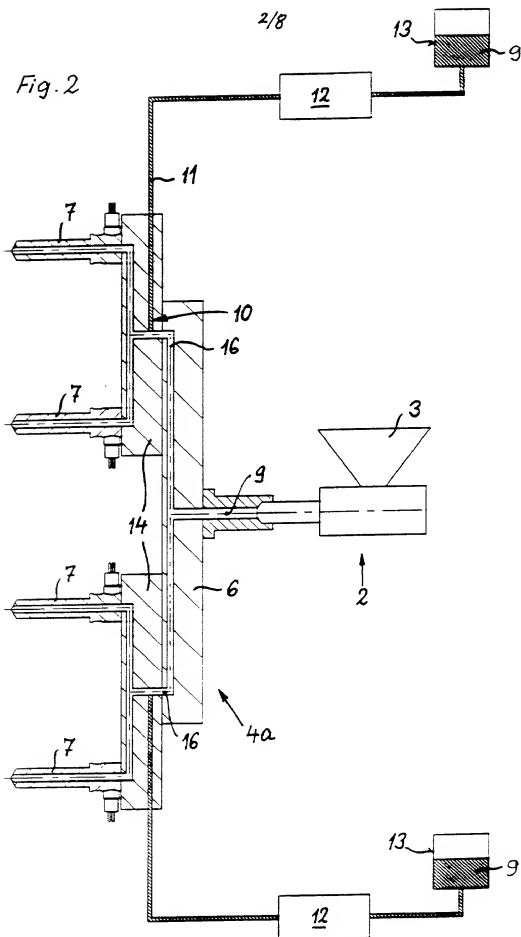
ABSTRACT

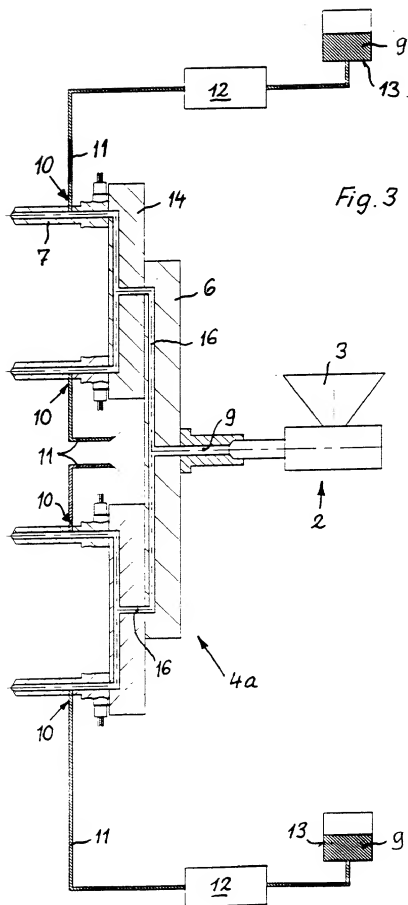
An injection molding machine for the manufacture of injection molded items, especially toothbrush bodies or toothbrushes, wherein the injection molding machine includes a mold-containing injection die (1) and an injection unit (2), especially with a screw-piston extruder or a similar material transport system. Distribution or transport channels lead from the injection unit (2) forming a distribution channel arrangement (4) to the individual mold cavities (5). One or more feeds (10) are located on the distribution channels and/or the mold cavities for at least one additive, for instance, a liquid color.

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Fig. 1

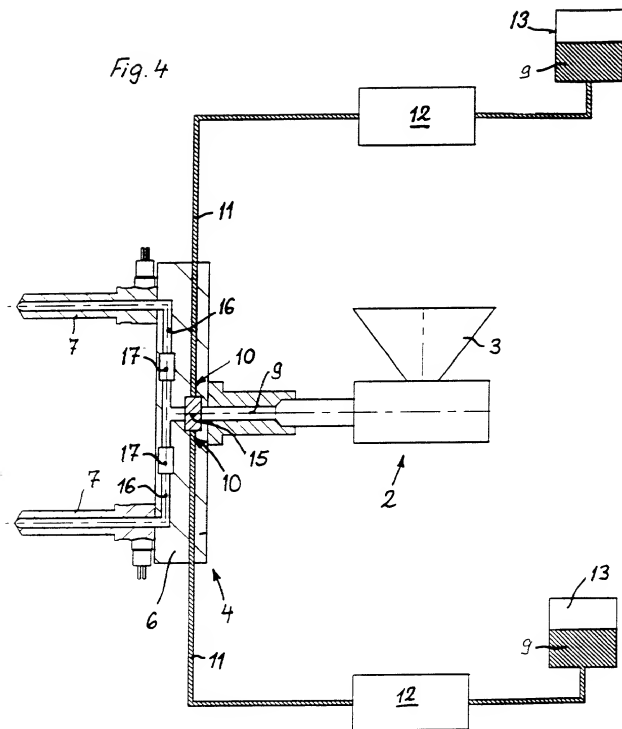






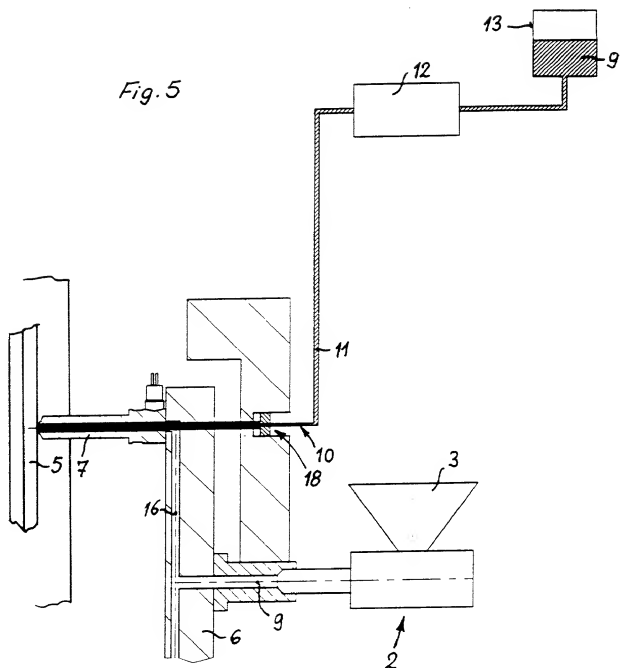
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Fig. 4



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Fig. 5



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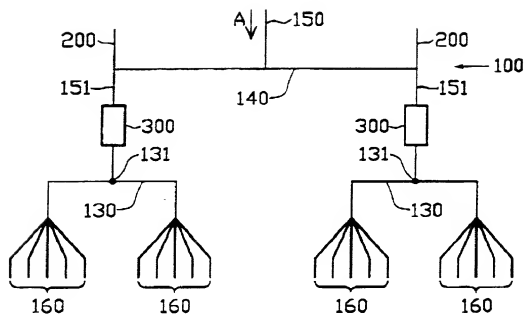


FIG. 6

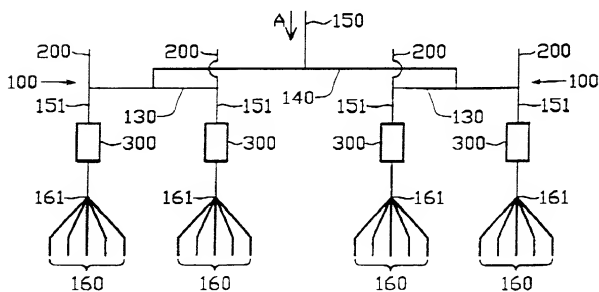
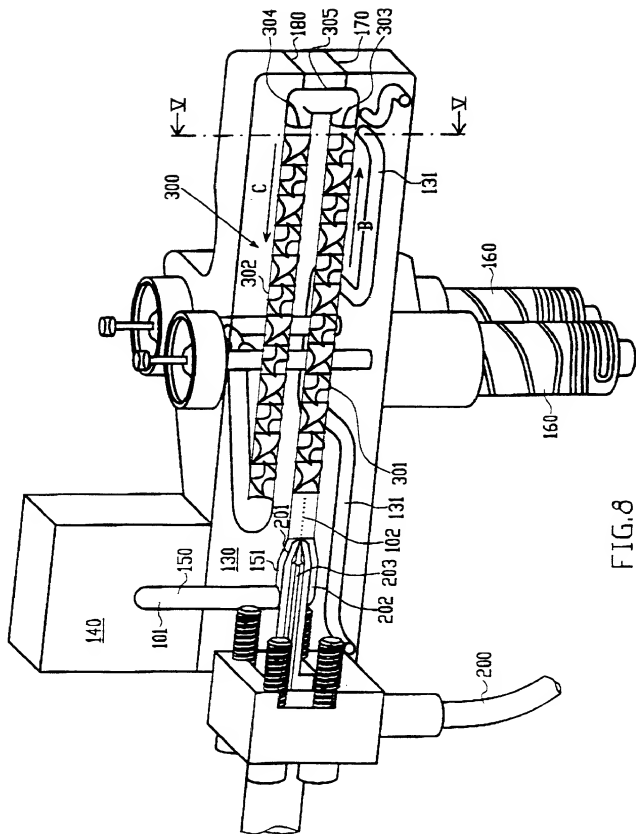


FIG. 7



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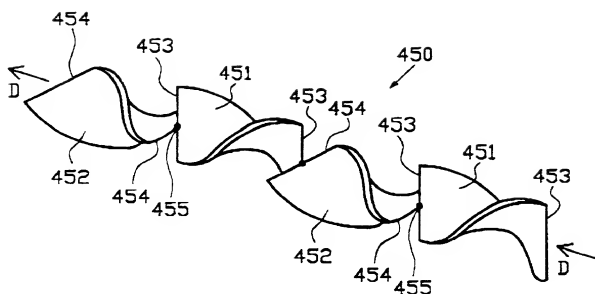


FIG. 9

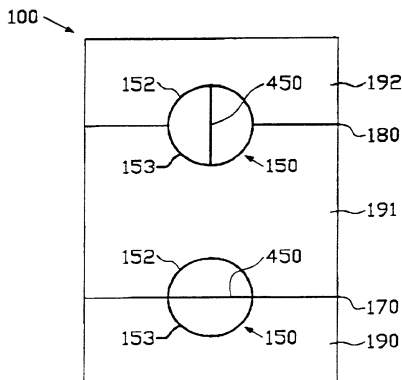


FIG. 10

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Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it contains a valid OMB control number.**DECLARATION FOR UTILITY OR
DESIGN
PATENT APPLICATION
(37 CFR 1.63)**

☒ Declaration Submitted with Initial Filing OR ☐ Declaration Submitted after Initial Filing (surcharge (37 CFR 1.16 (e)) required)

Attorney Docket Number	SMB-PT026 (PC 98 653 B US)
First Named Inventor	Zahoransky et al.
COMPLETE IF KNOWN	
Application Number	Not Yet Known
Filing Date	Not Yet Known
Group Art Unit	Not Yet Known
Examiner Name	Not Yet Known

As a below named inventor, I hereby declare that:

My residence, post office address, and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

METHOD AND INJECTION MOLDING MACHINE FOR PRODUCING INJECTION-MOLDED ARTICLES, ESPECIALLY TOOTHBRUSH BODIES OR TOOTHBRUSHES

the specification of which

(Title of the invention)

☐ is attached hereto
OR

☒ was filed on (MM/DD/YYYY) 12/30/1998 as United States Application Number or PCT InternationalApplication Number PCT/EP98/08509 and was amended on (MM/DD/YYYY) _____ (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment specifically referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR 1.56.

I hereby claim foreign priority benefits under 35 U.S.C. 119(a)-(d) or 365(b) of any foreign application(s) for patent or inventor's certificate, or 365(e) of any PCT International application which designated at least one country other than the United States of America, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate, or of any PCT International application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application Number(s)	Country	Foreign Filing Date (MM/DD/YYYY)	Priority Not Claimed	Certified Copy Attached?
			YES	NO
			<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>

☐ Additional foreign application numbers are listed on a supplemental priority data sheet PTO/SB/02B attached hereto.

I hereby claim the benefit under 35 U.S.C. 119(e) of any United States provisional application(s) listed below.

Application Number(s)	Filing Date (MM/DD/YYYY)	
		<input type="checkbox"/> Additional provisional application numbers are listed on a supplemental priority data sheet PTO/SB/02B attached hereto.

[Page 1 of 2]

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DECLARATION — Utility or Design Patent Application

I hereby claim the benefit under 35 U.S.C. 120 of any United States application(s), or 365(c) of any PCT International application designating the United States of America, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. 112, I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

U.S. Parent Application or PCT Parent Number	Parent Filing Date (MM/DD/YYYY)	Parent Patent Number (if applicable)
PCT/EP98/08509	12/30/1998	

☐ Additional U.S. or PCT International application numbers are listed on a supplemental priority data sheet PTO/SB/02B attached hereto.

As a named inventor, I hereby appoint the following registered practitioner(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

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<input type="checkbox"/> OR Registered practitioner(s) name/registration number listed below			
Name	Registration Number	Name	Registration Number
Namely, the Attorneys of Volpe and Koening, P.C.			

☐ Additional registered practitioner(s) named on supplemental Registered Practitioner Information sheet PTO/SB/02C attached hereto.

Direct all correspondence to: ☒ Customer Number or Bar Code Label 3624 ☐ OR ☐ Correspondence address below

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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true, and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under 18 U.S.C. 1001 and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Name of Sole or First Inventor:

☐ A petition has been filed for this unsigned inventor:

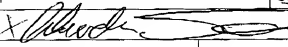
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☒ Additional inventors are being named on the 1 supplemental Additional Inventor(s) sheet(s) PTO/SB/02A attached hereto

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DECLARATION**ADDITIONAL INVENTOR(S)**
Supplemental Sheet
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Name of Additional Joint Inventor, if any:		<input type="checkbox"/> A petition has been filed for this unsigned inventor	
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